

Siapakah orang yang takut akan Tuhan? kepadanya Tuhan menunjukkan jalan yang harus dipilihnya. (Mazmur 25:12)

LAMPIRAN

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1. Simbol yang Digunakan Dalam Desain Ekonomi Peta Kendali \bar{X}

1.1 Output dan variabel yang dihitung:

n = sample size

h = hours between samples

L = number of standard deviations from control limits to center line

$$\tau = \frac{[1 - (1 + \lambda h)e^{-\lambda h}]}{[\lambda(1 - e^{-\lambda h})]}$$

$$s = \frac{e^{-\lambda h}}{(1 - e^{-\lambda h})}$$

ARL_1 = Average run length when in control

$$= \frac{1}{\alpha}$$

ARL_2 = Average run length when out of control

$$= \frac{1}{(1 - \beta)}$$

1.2 Input Variabel

λ = 1/mean time process is in control.

k = number of standard deviation slip when out of control.

E = time to sample and chart one item.

T_0 = expected search time when false alarm.

T_1 = expected search time to discover the assignable cause.

T_2 = expected search time to repair the process.

∂_1 = 1 if production continues during search.

= 0 if production ceases during search.

∂_2 = 1 if production continues during repair.

= 0 if production ceases during repair.

C_0 = quality cost/hour while producing in control .

C_1 = quality cost/hour while producing out control ($> C_0$).

Y = cost per false alarm.

W = cost to locate and repair the assignable cause.

a = fixed cost.

b = cost per unit sampled.

2. Pengaruh perubahan parameter biaya terhadap desain peta kendali \bar{X}

2.1 Perubahan a (fixed cost)

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
A	\$0.00	7	3	1.2	0.003	0.834	\$11.46	101.53	98.49	1.439
	\$0.01	7	3	1.2	0.003	0.834	\$11.46	101.53	98.49	1.439
	\$0.10	8	3	1.4	0.003	0.893	\$11.53	101.57	98.46	1.568
	\$0.20	8	3	1.4	0.003	0.893	\$11.60	101.57	98.46	1.568
	\$0.30	8	3	1.5	0.003	0.893	\$11.67	101.63	98.4	1.68
	\$0.40	8	2.95	1.6	0.003	0.902	\$11.74	101.68	98.35	1.774
	\$0.50	9	3	1.7	0.003	0.933	\$11.80	101.68	98.35	1.822
	\$0.60	9	3	1.8	0.003	0.933	\$11.85	101.74	98.29	1.929
	\$0.70	9	3	1.9	0.003	0.933	\$11.91	101.79	98.24	2.036
	\$0.80	9	3	1.9	0.003	0.933	\$11.96	101.79	98.24	2.036
	\$0.90	9	2.95	2	0.003	0.939	\$12.01	101.84	98.2	2.129
	\$1.00	9	2.95	2	0.003	0.939	\$12.06	101.84	98.2	2.129
	\$1.10	9	2.95	2.1	0.003	0.939	\$12.11	101.89	98.14	2.235
	\$1.20	9	2.95	2.1	0.003	0.939	\$12.16	101.89	98.14	2.235
	\$1.30	9	2.9	2.2	0.003	0.945	\$12.20	101.94	98.1	2.328
	\$1.40	10	3	2.3	0.003	0.959	\$12.25	101.96	98.07	2.397
	\$1.50	10	3	2.3	0.003	0.959	\$12.29	101.96	98.07	2.397
	\$1.60	10	2.95	2.4	0.003	0.964	\$12.33	102.01	98.03	2.491
	\$1.70	10	2.95	2.5	0.003	0.964	\$12.37	102.06	97.98	2.595
	\$1.80	10	2.95	2.5	0.003	0.964	\$12.41	102.06	97.98	2.595
	\$1.90	10	2.95	2.5	0.003	0.964	\$12.45	102.06	97.98	2.595
	\$2.00	10	2.95	2.6	0.003	0.964	\$12.49	102.12	97.93	2.698
	\$2.10	10	2.95	2.6	0.003	0.964	\$12.53	102.12	97.93	2.698
	\$2.20	10	2.95	2.7	0.003	0.964	\$12.57	102.17	97.88	2.802
	\$2.30	10	2.95	2.7	0.003	0.964	\$12.60	102.17	97.88	2.802
	\$2.40	10	2.9	2.8	0.004	0.967	\$12.64	102.21	97.83	2.894
	\$2.50	10	2.9	2.8	0.004	0.967	\$12.68	102.21	97.83	2.894
	\$2.60	10	2.9	2.8	0.004	0.967	\$12.71	102.21	97.83	2.894
	\$2.70	10	2.9	2.9	0.004	0.967	\$12.75	102.27	97.78	2.998
	\$2.80	10	2.9	2.9	0.004	0.967	\$12.78	102.27	97.78	2.998
	\$2.90	10	2.9	2.9	0.004	0.967	\$12.81	102.27	97.78	2.998
	\$3.00	10	2.9	3	0.004	0.967	\$12.85	102.32	97.73	3.101
	\$3.10	10	2.9	3	0.004	0.967	\$12.88	102.32	97.73	3.101
	\$3.20	10	2.85	3.1	0.004	0.971	\$12.91	102.36	97.69	3.193
	\$3.30	10	2.85	3.1	0.004	0.971	\$12.95	102.36	97.69	3.193
	\$3.40	11	2.95	3.2	0.003	0.979	\$12.98	102.4	97.66	3.27
	\$3.50	11	2.95	3.2	0.003	0.979	\$13.01	102.4	97.66	3.27
	\$3.60	11	2.95	3.3	0.003	0.979	\$13.04	102.45	97.61	3.372
	\$3.70	11	2.95	3.3	0.003	0.979	\$13.07	102.45	97.61	3.372
	\$3.80	11	2.95	3.3	0.003	0.979	\$13.10	102.45	97.61	3.372
	\$4.00	11	2.95	3.4	0.003	0.979	\$13.16	102.5	97.56	3.474
	\$4.10	11	2.95	3.4	0.003	0.979	\$13.19	102.5	97.56	3.474
	\$4.20	11	2.9	3.5	0.004	0.981	\$13.22	102.55	97.51	3.568
	\$4.30	11	2.9	3.5	0.004	0.981	\$13.25	102.55	97.51	3.568
	\$4.40	11	2.9	3.5	0.004	0.981	\$13.27	102.55	97.51	3.568
	\$4.50	11	2.9	3.6	0.004	0.981	\$13.30	102.6	97.47	3.67
	\$4.60	11	2.9	3.6	0.004	0.981	\$13.33	102.6	97.47	3.67
	\$4.70	11	2.9	3.6	0.004	0.981	\$13.36	102.6	97.47	3.67
	\$4.80	11	2.9	3.7	0.004	0.981	\$13.38	102.65	97.42	3.772
	\$4.90	11	2.9	3.7	0.004	0.981	\$13.41	102.65	97.42	3.772
	\$5.00	11	2.9	3.7	0.004	0.981	\$13.44	102.65	97.42	3.772
	\$5.10	11	2.9	3.7	0.004	0.981	\$13.47	102.65	97.42	3.772
	\$5.20	11	2.9	3.8	0.004	0.981	\$13.49	102.71	97.37	3.874
	\$5.30	11	2.9	3.8	0.004	0.981	\$13.52	102.71	97.37	3.874

	n	L	h	alpha	p	cost	ecl	%up & in control	ats
\$5.40	11	2.9	3.8	0.004	0.981	\$13.54	102.71	97.37	3.874
\$5.50	11	2.85	3.9	0.004	0.983	\$13.57	102.75	97.32	3.967
\$5.60	11	2.85	3.9	0.004	0.983	\$13.60	102.75	97.32	3.967
\$5.70	11	2.85	3.9	0.004	0.983	\$13.62	102.75	97.32	3.967
\$5.80	11	2.85	4	0.004	0.983	\$13.65	102.8	97.27	4.068
\$5.90	11	2.85	4	0.004	0.983	\$13.67	102.8	97.27	4.068
\$6.00	11	2.85	4	0.004	0.983	\$13.70	102.8	97.27	4.068
\$6.10	11	2.85	4.1	0.004	0.983	\$13.72	102.85	97.22	4.17
\$6.20	11	2.85	4.1	0.004	0.983	\$13.74	102.85	97.22	4.17
\$6.30	11	2.85	4.1	0.004	0.983	\$13.77	102.85	97.22	4.17

2.2 Perubahan b (variable cost)

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
B	\$0.00	11	3.5	0.3	0	0.93	\$10.32	100.9	99.11	0.323
	\$0.01	10	3.5	0.5	0	0.893	\$10.59	101.02	98.99	0.56
	\$0.10	7	3	1.2	0.003	0.834	\$11.46	101.53	98.49	1.439
	\$0.20	7	2.85	1.7	0.004	0.868	\$11.95	101.81	98.23	1.958
	\$0.30	6	2.65	1.9	0.008	0.847	\$12.31	102	98.04	2.243
	\$0.40	6	2.65	2.2	0.009	0.859	\$12.59	102.17	97.88	2.562
	\$0.50	6	2.55	2.5	0.011	0.87	\$12.85	102.33	97.72	2.875
	\$0.60	5	2.4	2.5	0.016	0.83	\$13.06	102.48	97.58	3.012
	\$0.70	5	2.4	2.6	0.016	0.83	\$13.26	102.55	97.51	3.133
	\$0.80	5	2.35	2.9	0.019	0.842	\$13.44	102.71	97.36	3.443
	\$0.90	5	2.3	3.1	0.021	0.854	\$13.60	102.81	97.27	3.63
	\$1.00	5	2.3	3.2	0.021	0.854	\$13.76	102.87	97.21	3.747
	\$1.10	5	2.25	3.4	0.024	0.865	\$13.91	102.96	97.13	3.93
	\$1.20	4	2.15	3.1	0.032	0.802	\$14.04	103.06	97.03	3.864
	\$1.30	4	2.15	3.2	0.032	0.802	\$14.17	103.13	96.96	3.988
	\$1.40	4	2.1	3.4	0.036	0.816	\$14.28	103.22	96.88	4.167
	\$1.50	4	2.1	3.5	0.036	0.816	\$14.40	103.29	96.81	4.29
	\$1.60	4	2.05	3.7	0.04	0.829	\$14.51	103.37	96.74	4.464
	\$1.70	4	2.05	3.8	0.04	0.829	\$14.62	103.44	96.67	4.584
	\$1.80	4	2.05	3.9	0.04	0.829	\$14.72	103.51	96.61	4.705
	\$1.90	4	2	4.1	0.046	0.841	\$14.82	103.59	96.54	4.873
	\$2.00	4	2	4.2	0.046	0.841	\$14.92	103.65	96.48	4.992
	\$2.10	4	2	4.2	0.046	0.841	\$15.01	103.65	96.48	4.992
	\$2.20	4	1.95	4.4	0.051	0.853	\$15.10	103.73	96.41	5.157
	\$2.30	4	1.95	4.5	0.051	0.853	\$15.19	103.79	96.35	5.275
	\$2.40	4	1.95	4.6	0.051	0.853	\$15.28	103.86	96.29	5.392
	\$2.50	3	1.85	4	0.064	0.773	\$15.35	103.98	96.18	5.176
	\$2.60	3	1.85	4	0.064	0.773	\$15.43	103.98	96.18	5.176
	\$2.70	3	1.8	4.2	0.072	0.788	\$15.50	104.04	96.11	5.333
	\$2.80	3	1.8	4.3	0.072	0.788	\$15.57	104.12	96.04	5.46
	\$2.90	3	1.8	4.3	0.072	0.788	\$15.64	104.12	96.04	5.46
	\$3.00	3	1.8	4.4	0.072	0.788	\$15.71	104.19	95.98	5.587
	\$3.10	3	1.8	4.4	0.072	0.788	\$15.78	104.19	95.98	5.587
	\$3.20	3	1.75	4.6	0.08	0.802	\$15.84	104.25	95.92	5.737
	\$3.30	3	1.75	4.7	0.08	0.802	\$15.91	104.33	95.85	5.862
	\$3.40	3	1.75	4.7	0.08	0.802	\$15.97	104.33	95.85	5.862
	\$3.50	3	1.75	4.8	0.08	0.802	\$16.03	104.4	95.79	5.986
	\$3.60	3	1.7	5	0.089	0.815	\$16.10	104.46	95.73	6.132
	\$3.70	3	1.7	5	0.089	0.815	\$16.16	104.46	95.73	6.132
	\$3.80	3	1.7	5.1	0.089	0.815	\$16.22	104.53	95.67	6.254
\$3.90	3	1.7	5.1	0.089	0.815	\$16.27	104.53	95.67	6.254	
\$4.00	3	1.7	5.2	0.089	0.815	\$16.33	104.6	95.61	6.377	

	n	L	h	alpha	p	cost	ecl	%up & in control	ats
\$4.10	3	1.7	5.2	0.089	0.815	\$16.39	104.6	95.61	6.377
\$4.20	3	1.65	5.4	0.099	0.828	\$16.44	104.65	95.56	6.158
\$4.30	3	1.65	5.4	0.099	0.828	\$16.50	104.65	95.56	6.158
\$4.40	3	1.65	5.5	0.099	0.828	\$16.55	104.72	95.49	6.639
\$4.50	3	1.65	5.5	0.099	0.828	\$16.61	104.72	95.49	6.639
\$4.60	3	1.65	5.6	0.099	0.828	\$16.66	104.79	95.43	6.759
\$4.70	3	1.65	5.6	0.099	0.828	\$16.72	104.79	95.43	6.759
\$4.80	3	1.6	5.8	0.11	0.841	\$16.77	104.84	95.38	6.897
\$4.90	3	1.6	5.9	0.11	0.841	\$16.82	104.91	95.32	7.016
\$5.00	3	1.6	5.9	0.11	0.841	\$16.87	104.91	95.32	7.016
\$5.10	3	1.6	6	0.11	0.841	\$16.92	104.97	95.26	7.135
\$5.20	2	1.5	4.8	0.134	0.733	\$16.97	105.06	95.18	6.549
\$5.30	2	1.5	4.9	0.134	0.733	\$17.01	105.14	95.11	6.685
\$5.40	2	1.5	4.9	0.134	0.733	\$17.05	105.14	95.11	6.685
\$5.50	2	1.5	4.9	0.134	0.733	\$17.09	105.14	95.11	6.685
\$5.60	2	1.45	5.1	0.147	0.749	\$17.13	105.18	95.07	6.808
\$5.70	2	1.45	5.1	0.147	0.749	\$17.17	105.18	95.07	6.808
\$5.80	2	1.45	5.2	0.147	0.749	\$17.21	105.26	95	6.941
\$5.90	2	1.45	5.2	0.147	0.749	\$17.24	105.26	95	6.941
\$6.00	2	1.45	5.2	0.147	0.749	\$17.28	105.26	95	6.941
\$6.10	2	1.45	5.3	0.147	0.749	\$17.32	105.34	94.93	7.075
\$6.20	2	1.45	5.3	0.147	0.749	\$17.36	105.34	94.93	7.075
\$6.30	2	1.4	5.5	0.162	0.762	\$17.40	105.37	94.9	7.191

2.3 Perubahan C_0 (quality cost/hour while producing in control).

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
C ₀	\$0.00	7	3	1.10	0.003	0.834	\$1.61	101.46	98.56	1.32
	\$0.01	7	3	1.10	0.003	0.834	\$1.62	101.46	98.56	1.32
	\$0.10	7	3	1.10	0.003	0.834	\$1.71	101.46	98.56	1.32
	\$0.20	7	3	1.10	0.003	0.834	\$1.81	101.46	98.56	1.32
	\$0.30	7	3	1.10	0.003	0.834	\$1.91	101.46	98.56	1.32
	\$0.40	7	3	1.10	0.003	0.834	\$2.00	101.46	98.56	1.32
	\$0.50	7	3	1.10	0.003	0.834	\$2.10	101.46	98.56	1.32
	\$0.60	7	3	1.10	0.003	0.834	\$2.20	101.46	98.56	1.32
	\$0.70	7	3	1.10	0.003	0.834	\$2.30	101.46	98.56	1.32
	\$0.80	7	3	1.10	0.003	0.834	\$2.40	101.46	98.56	1.32
	\$0.90	7	3	1.10	0.003	0.834	\$2.50	101.46	98.56	1.32
	\$1.00	7	3	1.10	0.003	0.834	\$2.60	101.46	98.56	1.32
	\$1.10	7	3	1.10	0.003	0.834	\$2.69	101.46	98.56	1.32
	\$1.20	7	3	1.10	0.003	0.834	\$2.79	101.46	98.56	1.32
	\$1.30	7	3	1.10	0.003	0.834	\$2.89	101.46	98.56	1.32
	\$1.40	7	3	1.10	0.003	0.834	\$2.99	101.46	98.56	1.32
	\$1.50	7	3	1.10	0.003	0.834	\$3.09	101.46	98.56	1.32
	\$1.60	7	3	1.10	0.003	0.834	\$3.19	101.46	98.56	1.32
	\$1.70	7	3	1.10	0.003	0.834	\$3.29	101.46	98.56	1.32
	\$1.80	7	3	1.10	0.003	0.834	\$3.38	101.46	98.56	1.32
	\$1.90	7	3	1.10	0.003	0.834	\$3.48	101.46	98.56	1.32
	\$2.00	7	3	1.10	0.003	0.834	\$3.58	101.46	98.56	1.32
	\$2.10	7	3	1.10	0.003	0.834	\$3.68	101.46	98.56	1.32
	\$2.20	7	3	1.10	0.003	0.834	\$3.78	101.46	98.56	1.32
	\$2.30	7	3	1.10	0.003	0.834	\$3.88	101.46	98.56	1.32
	\$2.40	7	3	1.10	0.003	0.834	\$3.98	101.46	98.56	1.32
	\$2.50	7	3	1.10	0.003	0.834	\$4.07	101.46	98.56	1.32
	\$2.60	7	3	1.10	0.003	0.834	\$4.17	101.46	98.56	1.32
	\$2.70	7	3	1.10	0.003	0.834	\$4.27	101.46	98.56	1.32

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
C ₀	\$2.80	7	3	1.10	0.003	0.834	\$4.37	101.46	98.56	1.32
	\$2.90	7	3	1.10	0.003	0.834	\$4.47	101.46	98.56	1.32
	\$3.00	7	3	1.10	0.003	0.834	\$4.57	101.46	98.56	1.32
	\$3.10	7	3	1.10	0.003	0.834	\$4.67	101.46	98.56	1.32
	\$3.20	7	3	1.10	0.003	0.834	\$4.76	101.46	98.56	1.32
	\$3.30	7	3	1.10	0.003	0.834	\$4.86	101.46	98.56	1.32
	\$3.40	7	3	1.10	0.003	0.834	\$4.96	101.46	98.56	1.32
	\$3.50	7	3	1.10	0.003	0.834	\$5.06	101.46	98.56	1.32
	\$3.60	7	3	1.10	0.003	0.834	\$5.16	101.46	98.56	1.32
	\$3.70	7	3	1.10	0.003	0.834	\$5.26	101.46	98.56	1.32
	\$3.80	7	3	1.10	0.003	0.834	\$5.36	101.46	98.56	1.32
	\$3.90	7	3	1.10	0.003	0.834	\$5.45	101.46	98.56	1.32
	\$4.00	7	3	1.10	0.003	0.834	\$5.55	101.46	98.56	1.32
	\$5.00	7	3	1.10	0.003	0.834	\$6.54	101.46	98.56	1.32
	\$6.00	7	3	1.10	0.003	0.834	\$7.52	101.46	98.46	1.32
	\$7.00	7	3	1.10	0.003	0.834	\$8.51	101.46	98.46	1.32
	\$8.00	7	3	1.20	0.003	0.834	\$9.49	101.53	98.49	1.439
	\$9.00	7	3	1.20	0.003	0.834	\$10.48	101.53	98.49	1.439
	\$10.00	7	3	1.20	0.003	0.834	\$11.46	101.53	98.49	1.439
	\$11.00	7	3	1.20	0.003	0.834	\$12.45	101.53	98.49	1.439
	\$12.00	7	3	1.20	0.003	0.834	\$13.43	101.53	98.49	1.439
	\$13.00	7	3	1.20	0.003	0.834	\$14.42	101.53	98.49	1.439
	\$14.00	7	3	1.20	0.003	0.834	\$15.40	101.53	98.49	1.439
	\$15.00	7	3	1.20	0.003	0.834	\$16.39	101.53	98.49	1.439
	\$16.00	7	3	1.20	0.003	0.834	\$17.37	101.53	98.49	1.439
	\$17.00	7	3	1.20	0.003	0.834	\$18.36	101.53	98.49	1.439
	\$18.00	7	3	1.20	0.003	0.834	\$19.34	101.53	98.49	1.439
	\$19.00	7	3	1.20	0.003	0.834	\$20.33	101.53	98.49	1.439
	\$20.00	7	3	1.20	0.003	0.834	\$21.31	101.53	98.49	1.439
	\$21.00	7	3	1.20	0.003	0.834	\$22.30	101.53	98.49	1.439
	\$22.00	7	3	1.20	0.003	0.834	\$23.28	101.53	98.49	1.439
	\$23.00	7	3	1.30	0.003	0.834	\$24.27	101.6	98.43	1.559
	\$24.00	7	3	1.30	0.003	0.834	\$25.25	101.6	98.42	1.559
	\$25.00	7	3	1.30	0.003	0.834	\$26.24	101.6	98.42	1.559
	\$26.00	7	3	1.30	0.003	0.834	\$27.22	101.6	98.42	1.559
	\$27.00	7	3	1.30	0.003	0.834	\$28.20	101.6	98.42	1.559
	\$28.00	7	3	1.30	0.003	0.834	\$29.19	101.6	98.42	1.559
	\$29.00	7	3	1.30	0.003	0.834	\$30.17	101.6	98.42	1.559
	\$30.00	7	3	1.30	0.003	0.834	\$31.16	101.6	98.42	1.559
	\$31.00	7	3	1.30	0.003	0.834	\$32.14	101.6	98.42	1.559
	\$32.00	7	3	1.30	0.003	0.834	\$33.13	101.6	98.42	1.559
	\$33.00	7	3	1.30	0.003	0.834	\$34.11	101.6	98.42	1.559
	\$34.00	7	2.95	1.40	0.003	0.846	\$35.09	101.65	98.38	1.655
	\$35.00	7	3	1.40	0.003	0.834	\$36.08	101.67	98.36	1.679
	\$36.00	7	3	1.40	0.003	0.834	\$37.06	101.67	98.36	1.679
	\$37.00	7	3	1.40	0.003	0.834	\$38.04	101.67	98.36	1.679
	\$38.00	7	3	1.40	0.003	0.834	\$39.03	101.67	98.36	1.679
	\$39.00	7	3	1.40	0.003	0.0834	\$40.01	101.67	98.36	1.679
	\$40.00	7	3	1.40	0.003	0.834	\$40.99	101.67	98.36	1.679
	\$41.00	7	3	1.40	0.003	0.834	\$41.98	101.67	98.36	1.679
	\$42.00	7	2.95	1.50	0.003	0.846	\$42.96	101.72	98.31	1.773
	\$43.00	7	2.95	1.50	0.003	0.846	\$43.94	101.72	98.31	1.773
	\$44.00	7	2.95	1.50	0.003	0.846	\$44.93	101.72	98.31	1.773
	\$45.00	7	3	1.50	0.003	0.834	45.91.08	101.74	98.29	1.799
	\$46.00	7	3	1.50	0.003	0.834	\$46.89	101.74	98.29	1.799
	\$47.00	7	3	1.50	0.003	0.834	\$47.88	101.74	98.29	1.799
	\$48.00	7	3	1.50	0.003	0.834	\$48.86	101.74	98.29	1.799
	\$49.00	7	2.95	1.60	0.003	0.846	\$49.84	101.78	98.25	1.892
	\$50.00	7	2.95	1.60	0.003	0.846	\$50.82	101.78	98.25	1.892
	\$51.00	7	2.95	1.60	0.003	0.846	\$51.81	101.78	98.25	1.892

	n	L	h	alpha	p	cost	ecl	%up & in control	ats
\$52.00	7	3	1.60	0.003	0.846	\$52.79	101.78	98.22	1.919
\$53.00	7	3	1.60	0.003	0.846	\$53.77	101.81	98.22	1.919
\$54.00	7	3	1.60	0.003	0.846	\$54.75	101.81	98.22	1.919
\$55.00	7	2.95	1.70	0.003	0.846	\$55.74	101.85	98.18	2.01
\$56.00	7	2.95	1.70	0.003	0.846	\$56.72	101.85	98.18	2.01
\$57.00	7	2.95	1.70	0.003	0.846	\$57.70	101.85	98.18	2.01
\$58.00	7	3	1.70	0.003	0.834	\$58.68	101.88	98.16	2.039
\$59.00	7	3	1.70	0.003	0.834	\$59.66	101.88	98.16	2.039
\$60.00	7	2.95	1.80	0.003	0.846	\$60.64	101.92	98.12	2.128
\$61.00	7	2.95	1.80	0.003	0.846	\$61.63	101.92	98.12	2.128
\$62.00	7	2.95	1.80	0.003	0.846	\$62.61	101.92	98.12	2.128
\$63.00	7	3	1.80	0.003	8.34	\$63.59	101.95	98.09	2.159
\$64.00	7	2.95	1.90	0.003	0.846	\$64.57	101.99	98.05	2.246
\$65.00	7	2.95	1.90	0.003	0.846	\$65.55	101.99	98.05	2.246
\$66.00	7	2.95	1.90	0.003	0.846	\$66.53	101.99	98.05	2.246
\$67.00	7	2.95	2.00	0.003	0.846	\$67.51	102.05	97.99	2.365
\$68.00	7	2.95	2.00	0.003	0.846	\$68.49	102.05	97.99	2.365
\$69.00	7	2.95	2.00	0.003	0.846	\$69.47	102.05	97.99	2.365
\$70.00	7	2.95	2.00	0.003	0.846	\$70.45	102.05	97.99	2.365
\$71.00	7	2.95	2.10	0.003	0.846	\$71.43	102.12	97.92	2.483
\$72.00	7	2.95	2.10	0.003	0.846	\$72.41	102.12	97.92	2.483
\$73.00	7	2.95	2.20	0.003	0.846	\$73.39	102.19	97.86	2.601
\$74.00	7	2.95	2.20	0.003	0.846	\$74.37	102.19	97.86	2.601
\$75.00	7	2.95	2.20	0.003	0.846	\$75.34	102.19	97.86	2.601
\$76.00	7	2.95	2.30	0.003	0.846	\$76.32	102.26	97.79	2.719
\$77.00	7	2.95	2.30	0.003	0.846	\$77.30	102.26	97.79	2.719
\$78.00	7	2.95	2.40	0.003	0.846	\$78.28	102.33	97.73	2.838
\$79.00	7	2.95	2.40	0.003	0.846	\$79.26	102.33	97.73	2.838
\$80.00	7	2.95	2.50	0.003	0.846	\$80.23	102.39	97.66	2.956
\$81.00	7	2.95	2.60	0.003	0.846	\$81.21	102.46	97.6	3.074
\$82.00	7	2.95	2.60	0.003	0.846	\$82.18	102.46	97.6	3.074
\$83.00	7	2.95	2.70	0.003	0.846	\$83.16	102.53	97.53	3.192
\$84.00	7	2.95	2.80	0.003	0.846	\$84.14	102.6	97.47	3.31
\$85.00	7	2.95	2.90	0.003	0.846	\$85.11	102.67	97.4	3.429
\$86.00	7	2.95	3.00	0.003	0.846	\$86.08	102.73	97.34	3.547
\$87.00	7	2.95	3.10	0.003	0.846	\$87.06	102.8	97.27	3.665
\$88.00	7	2.95	3.20	0.003	0.846	\$88.03	102.87	97.21	3.783
\$89.00	7	2.95	3.30	0.003	0.846	\$89.00	102.94	97.14	3.902
\$90.00	7	2.95	3.50	0.003	0.846	\$89.97	103.08	97.01	4.138
\$91.00	7	2.95	3.70	0.003	0.846	\$90.94	103.21	96.89	4.375
\$92.00	7	2.95	3.90	0.003	0.846	\$91.91	103.35	96.76	4.611
\$93.00	7	2.95	4.10	0.003	0.846	\$92.88	103.49	96.63	4.847
\$94.00	7	2.95	4.40	0.003	0.846	\$93.84	103.7	96.44	5.202
\$95.00	7	2.95	4.80	0.003	0.846	\$94.81	103.97	96.18	5.675
\$96.00	7	2.95	5.40	0.003	0.846	\$95.77	104.38	95.8	6.386
\$97.00	7	2.95	6.10	0.003	0.846	\$96.72	104.87	95.36	7.212
\$98.00	7	2.95	7.20	0.003	0.846	\$97.67	105.63	94.67	8.513
\$99.00	7	2.95	9.00	0.003	0.846	\$98.61	106.88	93.56	10.641

2.4 Perubahan C1 (quality cost/hour while producing out control)

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
C1	\$15.00	8	3.05	5.5	0.002	0.883	\$10.30	104.18	95.98	6.225
	\$20.00	8	3.05	3.9	0.002	0.883	\$10.44	103.16	96.93	4.414
	\$25.00	8	3.05	3.2	0.002	0.883	\$10.55	102.72	97.35	3.622
	\$30.00	8	3.05	2.7	0.002	0.883	\$10.65	102.4	97.66	3.056
	\$35.00	8	3.05	2.4	0.002	0.883	\$10.73	102.21	97.84	2.716
	\$40.00	8	3.05	2.2	0.002	0.883	\$10.81	102.08	97.96	2.49
	\$45.00	8	3.05	2.1	0.002	0.883	\$10.88	102.02	98.02	2.377
	\$50.00	8	3.05	1.9	0.002	0.883	\$10.95	101.9	98.14	2.151
	\$55.00	8	3.05	1.8	0.002	0.883	\$11.01	101.83	98.2	2.037
	\$60.00	8	3.05	1.7	0.002	0.883	\$11.07	101.77	98.26	1.924
	\$65.00	7	3	1.5	0.003	0.834	\$11.12	101.74	98.29	1.799
	\$70.00	8	3.05	1.6	0.002	0.883	\$11.18	101.71	98.32	1.811
	\$75.00	8	3.05	1.5	0.02	0.883	\$11.23	101.64	98.38	1.698
	\$80.00	7	3	1.3	0.003	0.834	\$11.28	101.6	98.42	1.559
	\$85.00	7	3	1.3	0.003	0.834	\$11.33	101.6	98.42	1.559
	\$90.00	7	3	1.2	0.003	0.834	\$11.37	101.53	98.49	1.439
	\$95.00	7	3	1.2	0.003	0.834	\$11.42	101.53	98.49	1.439
	\$100.00	7	3	1.2	0.003	0.834	\$11.46	101.53	98.49	1.439
	\$105.00	7	3	1.1	0.003	0.834	\$11.51	101.46	98.56	1.32
	\$110.00	7	3	1.1	0.003	0.834	\$11.55	101.46	98.56	1.32
C1	\$115.00	7	3	1.1	0.003	0.834	\$11.59	101.46	98.56	1.32
	\$120.00	7	3	1.1	0.003	0.834	\$11.63	101.46	98.56	1.32
	\$125.00	7	3	1	0.03	0.834	\$11.67	101.4	98.62	1.2
	\$130.00	7	3	1	0.03	0.834	\$11.71	101.4	98.62	1.2
	\$135.00	7	3	1	0.03	0.834	\$11.75	101.4	98.62	1.2
	\$140.00	7	3	1	0.03	0.834	\$11.78	101.4	98.62	1.2
	\$145.00	7	3	1	0.03	0.834	\$11.82	101.4	98.62	1.2
	\$150.00	7	3	0.9	0.03	0.834	\$11.86	101.33	98.69	1.08
	\$155.00	7	3	0.9	0.03	0.834	\$11.89	101.33	98.69	1.08
	\$160.00	7	3	0.9	0.03	0.834	\$11.93	101.33	98.69	1.08
	\$165.00	7	3	0.9	0.03	0.834	\$11.96	101.33	98.69	1.08
	\$170.00	7	3	0.9	0.03	0.834	\$11.99	101.33	98.69	1.08
	\$175.00	7	3	0.9	0.03	0.834	\$12.03	101.33	98.69	1.08
	\$180.00	7	3	0.8	0.03	0.834	\$12.06	101.26	98.75	0.96
	\$185.00	7	3	0.8	0.03	0.834	\$12.09	101.26	98.75	0.96
	\$190.00	7	3	0.8	0.03	0.834	\$12.16	101.26	98.75	0.96
	\$195.00	7	3	0.8	0.03	0.834	\$12.16	101.26	98.75	0.96
	\$200.00	7	3	0.8	0.03	0.834	\$12.19	101.26	98.75	0.96
	\$205.00	7	3	0.8	0.03	0.834	\$12.22	101.26	98.75	0.96
	\$210.00	7	3	0.8	0.03	0.834	\$12.25	101.26	98.75	0.96
	\$215.00	7	3	0.8	0.03	0.834	\$12.28	101.26	98.75	0.96
	\$220.00	7	3	0.8	0.03	0.834	\$12.31	101.26	98.75	0.96
	\$225.00	7	2.95	0.8	0.03	0.846	\$12.34	101.26	98.76	0.946
	\$230.00	7	3	0.7	0.003	0.834	\$12.37	101.2	98.82	0.84
	\$235.00	7	3	0.7	0.003	0.834	\$12.40	101.2	98.82	0.84
	\$240.00	7	3	0.7	0.003	0.834	\$12.43	101.2	98.82	0.84
	\$245.00	7	3	0.7	0.003	0.834	\$12.46	101.2	98.82	0.84
	\$250.00	7	3	0.7	0.003	0.834	\$12.48	101.2	98.82	0.84
	\$255.00	7	3	0.7	0.003	0.834	\$12.51	101.2	98.82	0.84
	\$260.00	7	3	0.7	0.003	0.834	\$12.54	101.2	98.82	0.84
	\$265.00	7	3	0.7	0.003	0.834	\$12.57	101.2	98.82	0.84
	\$270.00	7	3	0.7	0.003	0.834	\$12.59	101.2	98.82	0.84
	\$275.00	7	3	0.7	0.003	0.834	\$12.62	101.2	98.82	0.84
	\$280.00	7	3	0.7	0.003	0.834	\$12.65	101.2	98.82	0.84
	\$285.00	7	3	0.7	0.003	0.834	\$12.68	101.2	98.82	0.84
	\$290.00	7	2.95	0.7	0.003	0.834	\$12.70	101.19	98.82	0.828
	\$295.00	7	2.95	0.7	0.003	0.846	\$12.73	101.19	98.82	0.828
	\$300.00	7	3.05	0.6	0.002	0.821	\$12.76	101.14	98.87	0.731

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
	\$305.00	7	3.05	0.6	0.002	0.821	\$12.78	101.14	98.87	0.731
	\$310.00	7	3	0.6	0.003	0.834	\$12.81	101.13	98.88	0.72
	\$315.00	7	3	0.6	0.003	0.834	\$12.83	101.13	98.88	0.72
	\$320.00	7	3	0.6	0.003	0.834	\$12.86	101.13	98.88	0.72
	\$325.00	7	3	0.6	0.003	0.834	\$12.88	101.13	98.88	0.72

2.5 Perubahan Y (cost per false alarm)

		n	L	h	alpha	p	Cost	ecl	%up & in control	ats
Y	\$0.00	1	1.6	0	0.11	0.46	\$10.11	111.7	89.5	0.22
	\$1.00	1	1	0	0.32	0.7	\$10.53	111.5	89.73	0.43
	\$2.00	2	1.5	1	0.15	0.75	\$10.98	103.3	96.81	0.93
	\$3.00	3	1.9	1	0.06	0.77	\$11.09	102.1	97.98	1.04
	\$4.00	4	2.1	1	0.04	0.83	\$11.14	101.7	98.31	1.09
	\$5.00	4	2.2	1	0.03	0.8	\$11.18	101.7	98.37	1.12
	\$6.00	5	2.3	1	0.02	0.84	\$11.21	101.5	98.49	1.17
	\$7.00	5	2.4	1	0.02	0.84	\$11.23	101.5	98.5	1.19
	\$8.00	5	2.4	1	0.02	0.83	\$11.25	101.5	98.5	1.21
	\$9.00	5	2.4	1	0.02	0.83	\$11.27	101.5	98.5	1.21
	\$10.00	5	2.5	1	0.01	0.82	\$11.28	101.5	98.51	1.22
	\$11.00	5	2.5	1	0.01	0.82	\$11.29	101.5	98.51	1.22
	\$12.00	6	2.6	1	0.01	0.87	\$11.31	101.5	98.55	1.27
	\$13.00	6	2.6	1	0.01	0.87	\$11.31	101.5	98.55	1.27
	\$14.00	6	2.6	1	0.01	0.86	\$11.32	101.5	98.55	1.28
	\$15.00	6	2.7	1	0.01	0.85	\$11.33	101.5	98.54	1.3
	\$16.00	6	2.7	1	0.01	0.85	\$11.34	101.5	98.54	1.3
	\$17.00	6	2.7	1	0.01	0.49	\$11.34	101.5	98.54	1.3
	\$18.00	6	2.7	1	0.01	0.84	\$11.35	101.5	98.53	1.32
	\$19.00	6	2.7	1	0.01	0.84	\$11.36	101.5	98.53	1.32
	\$20.00	6	2.7	1	0.01	0.84	\$11.36	101.5	98.53	1.32
	\$21.00	6	2.7	1	0.01	0.84	\$11.37	101.5	98.53	1.32
	\$22.00	6	2.8	1	0.01	0.82	\$11.38	101.5	98.52	1.34
	\$23.00	6	2.8	1	0.01	0.82	\$11.31	101.5	98.52	1.34
	\$24.00	6	2.8	1	0.01	0.82	\$11.39	101.5	98.52	1.34
	\$25.00	7	2.9	1	0	0.87	\$11.39	101.5	98.53	1.38
	\$26.00	7	2.9	1	0	0.87	\$11.39	101.5	98.53	1.38
	\$27.00	7	2.9	1	0	0.87	\$11.40	101.5	98.53	1.38
	\$28.00	7	2.9	1	0	0.87	\$11.40	101.5	98.53	1.38
	\$29.00	7	2.9	1	0	0.87	\$11.41	101.5	98.53	1.38
	\$30.00	7	2.9	1	0	0.87	\$11.41	101.5	98.53	1.38
	\$31.00	7	2.9	1	0	0.86	\$11.41	101.5	98.52	1.4
	\$32.00	7	2.9	1	0	0.86	\$11.42	101.5	98.52	1.4
	\$33.00	7	2.9	1	0	0.86	\$11.42	101.5	98.52	1.4
	\$34.00	7	2.9	1	0	0.86	\$11.42	101.5	98.52	1.4
	\$35.00	7	2.9	1	0	0.86	\$11.42	101.5	98.52	1.4
	\$36.00	7	2.9	1	0	0.86	\$11.43	101.5	98.52	1.4
	\$37.00	7	2.9	1	0	0.86	\$1.43	101.5	98.52	1.4
	\$38.00	7	2.9	1	0	0.86	\$11.43	101.5	98.52	1.4
	\$39.00	7	3	1	0	0.85	\$11.44	101.5	98.51	1.42
	\$40.00	7	3	1	0	0.85	\$11.44	101.5	98.51	1.42
	\$41.00	7	3	1	0	0.85	\$11.44	101.5	98.51	1.42
	\$42.00	7	3	1	0	0.85	\$11.44	101.5	98.51	1.42
	\$43.00	7	3	1	0	0.85	\$11.45	101.5	98.51	1.42
	\$44.00	7	3	1	0	0.85	\$11.45	101.5	98.51	1.42
	\$45.00	7	3	1	0	0.85	\$11.45	101.5	98.51	1.42
	\$46.00	7	3	1	0	0.85	\$11.45	101.5	98.51	1.42
	\$47.00	7	3	1	0	0.85	\$11.46	101.5	98.51	1.42
	\$48.00	7	3	1	0	0.83	\$11.46	101.5	98.49	1.44

Y	\$49.00	7	3	1	0	0.83	\$11.46	101.5	98.49	1.44
	\$50.00	7	3	1	0	0.83	\$11.46	101.5	98.49	1.44
	\$51.00	7	3	1	0	0.83	\$11.47	101.5	98.49	1.44
	\$52.00	8	3.1	1	0	0.88	\$11.47	101.5	98.5	1.47
	\$53.00	8	3.1	1	0	0.88	\$11.47	101.5	98.5	1.47
	\$54.00	8	3.1	1	0	0.88	\$11.47	101.5	98.5	1.47
	\$55.00	8	3.1	1	0	0.88	\$11.47	101.5	98.5	1.47
	\$56.00	8	3.1	1	0	0.88	\$11.48	101.5	98.5	1.47
	\$57.00	8	3.1	1	0	0.88	\$11.48	101.5	98.5	1.47
	\$58.00	8	3.1	1	0	0.87	\$11.48	101.5	98.49	1.49
	\$59.00	8	3.1	1	0	0.87	\$11.48	101.5	98.49	1.49
	\$60.00	8	3.1	1	0	0.87	\$11.48	101.5	98.49	1.49
	\$61.00	8	3.1	1	0	0.87	\$11.48	101.5	98.49	1.49
	\$62.00	8	3.1	1	0	0.87	\$11.48	101.5	98.49	1.49
	\$63.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$64.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$65.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$66.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$67.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$68.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$69.00	8	3.1	1	0	0.87	\$11.49	101.5	98.49	1.49
	\$70.00	8	3.1	1	0	0.87	\$11.50	101.5	98.49	1.49
	\$71.00	8	3.1	1	0	0.87	\$11.50	101.5	98.49	1.49
	\$72.00	8	3.1	1	0	0.87	\$11.50	101.5	98.49	1.49
	\$73.00	8	3.1	1	0	0.87	\$11.50	101.5	98.49	1.49
	\$74.00	8	3.2	1	0	0.86	\$11.50	101.6	98.47	1.51

2.6 Perubahan W (cost to locate and repair the assignable cause)

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
W	\$0.00	7	3	1.2	0.003	0.834	\$11.44	101.53	98.49	1.439
	\$2.00	7	3	1.2	0.003	0.834	\$11.46	101.53	98.49	1.439
	\$10.00	7	3	1.2	0.003	0.834	\$11.54	101.53	98.49	1.439
	\$20.00	7	3	1.2	0.003	0.834	\$11.64	101.53	98.49	1.439
	\$30.00	7	3	1.2	0.003	0.834	\$11.74	101.53	98.49	1.439
	\$40.00	7	3	1.2	0.003	0.834	\$11.84	101.53	98.49	1.439
	\$50.00	7	3	1.2	0.003	0.834	\$11.94	101.53	98.49	1.439
	\$60.00	7	3	1.2	0.003	0.834	\$12.04	101.53	98.49	1.439
	\$70.00	7	3	1.2	0.003	0.834	\$12.13	101.53	98.49	1.439
	\$80.00	7	3	1.2	0.003	0.834	\$12.23	101.53	98.49	1.439
	\$90.00	7	3	1.2	0.003	0.834	\$12.33	101.53	98.49	1.439
	\$100.00	7	3	1.2	0.003	0.834	\$12.43	101.53	98.49	1.439
	\$110.00	7	3	1.2	0.003	0.834	\$12.53	101.53	98.49	1.439
	\$120.00	7	3	1.2	0.003	0.834	\$12.63	101.53	98.49	1.439
	\$130.00	7	3	1.2	0.003	0.834	\$12.72	101.53	98.49	1.439
	\$140.00	7	3	1.2	0.003	0.834	\$12.82	101.53	98.49	1.439
	\$150.00	7	3	1.2	0.003	0.834	\$12.92	101.53	98.49	1.439
	\$160.00	7	3	1.2	0.003	0.834	\$13.02	101.53	98.49	1.439
	\$170.00	7	3	1.2	0.003	0.834	\$13.12	101.53	98.49	1.439
	\$180.00	7	3	1.2	0.003	0.834	\$13.22	101.53	98.49	1.439
	\$190.00	7	3	1.2	0.003	0.834	\$13.32	101.53	98.49	1.439
	\$200.00	7	3	1.2	0.003	0.834	\$13.41	101.53	98.49	1.439
	\$210.00	7	3	1.2	0.003	0.834	\$13.51	101.53	98.49	1.439
	\$220.00	7	3	1.2	0.003	0.834	\$13.61	101.53	98.49	1.439
	\$230.00	7	3	1.2	0.003	0.834	\$13.71	101.53	98.49	1.439
	\$240.00	7	3	1.2	0.003	0.834	\$13.81	101.53	98.49	1.439
	\$250.00	7	3	1.2	0.003	0.834	\$13.91	101.53	98.49	1.439
	\$260.00	7	3	1.2	0.003	0.834	\$14.00	101.53	98.49	1.439
	\$270.00	7	3	1.2	0.003	0.834	\$14.10	101.53	98.49	1.439

		n	L	h	alpha	p	cost	ecl	%up & in control	ats
	\$280.00	7	3	1.2	0.003	0.834	\$14.20	101.53	98.49	1.439
	\$290.00	7	3	1.2	0.003	0.834	\$14.30	101.53	98.49	1.439
	\$300.00	7	3	1.2	0.003	0.834	\$14.40	101.53	98.49	1.439
	\$310.00	7	3	1.2	0.003	0.834	\$14.50	101.53	98.49	1.439
	\$320.00	7	3	1.2	0.003	0.834	\$14.60	101.53	98.49	1.439
	\$330.00	7	3	1.2	0.003	0.834	\$14.69	101.53	98.49	1.439
	\$340.00	7	3	1.2	0.003	0.834	\$14.79	101.53	98.49	1.439
	\$350.00	7	3	1.2	0.003	0.834	\$14.89	101.53	98.49	1.439
	\$360.00	7	3	1.2	0.003	0.834	\$14.99	101.53	98.49	1.439
	\$370.00	7	3	1.2	0.003	0.834	\$15.09	101.53	98.49	1.439
	\$380.00	7	3	1.2	0.003	0.834	\$15.19	101.53	98.49	1.439
	\$390.00	7	3	1.2	0.003	0.834	\$15.29	101.53	98.49	1.439
	\$400.00	7	3	1.2	0.003	0.834	\$15.38	101.53	98.49	1.439
	\$410.00	7	3	1.2	0.003	0.834	\$15.48	101.53	98.49	1.439
	\$420.00	7	3	1.2	0.003	0.834	\$15.58	101.53	98.49	1.439
	\$430.00	7	3	1.2	0.003	0.834	\$15.68	101.53	98.49	1.439
	\$440.00	7	3	1.2	0.003	0.834	\$15.78	101.53	98.49	1.439
	\$450.00	7	3	1.2	0.003	0.834	\$15.88	101.53	98.49	1.439
	\$460.00	7	3	1.2	0.003	0.834	\$15.97	101.53	98.49	1.439
	\$470.00	7	3	1.2	0.003	0.834	\$16.07	101.53	98.49	1.439
	\$480.00	7	3	1.2	0.003	0.834	\$16.17	101.53	98.49	1.439
	\$490.00	7	3	1.2	0.003	0.834	\$16.27	101.53	98.49	1.439
	\$500.00	7	3	1.2	0.003	0.834	\$16.37	101.53	98.49	1.439
	\$510.00	7	3	1.2	0.003	0.834	\$16.47	101.53	98.49	1.439
	\$520.00	7	3	1.2	0.03	0.834	\$16.57	101.53	98.49	1.439
	\$530.00	7	3	1.2	0.03	0.834	\$16.66	101.53	98.49	1.439
	\$540.00	7	3	1.2	0.03	0.834	\$16.76	101.53	98.49	1.439
	\$550.00	7	3	1.2	0.03	0.834	\$16.86	101.53	98.49	1.439
	\$560.00	7	3	1.2	0.03	0.834	\$16.96	101.53	98.49	1.439
	\$570.00	7	3	1.2	0.03	0.834	\$17.06	101.53	98.49	1.439
	\$580.00	7	3	1.2	0.03	0.834	\$17.16	101.53	98.49	1.439
	\$590.00	7	3	1.2	0.03	0.834	\$17.26	101.53	98.49	1.439
	\$600.00	7	3	1.2	0.03	0.834	\$17.35	101.53	98.49	1.439
	\$610.00	7	3	1.2	0.03	0.834	\$17.45	101.53	98.49	1.439

3. Listing Output Program

3.1 Perubahan *a* (fixedcost)

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 11.46

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5798

TOTAL 11.4555

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4638

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.00 H= 1.400 COST= 11.53

***** SUMMARY INFO FOR PLAN N= 8 L= 3.00 H= 1.400 *****

HOURLY COSTS: ECL = 101.57 HOURS

% OF TIME UP & IN CONTROL: 98.46

NONCONFORMING ITEMS 10.7803 ALPHA = 0.003

FALSE ALARMS 0.0943 P = 0.893

ASSIGNABLE CAUSES 0.0197 ATS = 1.568 HOURS

SAMPLING 0.6389

TOTAL 11.5332

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.20 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.00 H= 1.400 COST= 11.60

***** SUMMARY INFO FOR PLAN N= 8 L= 3.00 H= 1.400 *****

HOURLY COSTS: ECL = 101.57 HOURS

% OF TIME UP & IN CONTROL: 98.46

NONCONFORMING ITEMS 10.7803 ALPHA = 0.003

FALSE ALARMS 0.0943 P = 0.893

ASSIGNABLE CAUSES 0.0197 ATS = 1.568 HOURS

SAMPLING 0.7099

TOTAL 11.6042

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.30 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.00 H = 1.500 COST = 11.67

***** SUMMARY INFO FOR PLAN N = 8 L = 3.00 H = 1.500 *****

HOURLY COSTS: ECL = 101.63 HOURS

% OF TIME UP & IN CONTROL: 98.40

NONCONFORMING ITEMS 10.8351 ALPHA = 0.003

FALSE ALARMS 0.0879 P = 0.893

ASSIGNABLE CAUSES 0.0197 ATS = 1.680 HOURS

SAMPLING 0.7289

TOTAL 11.6715

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.40 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 2.95 H = 1.600 COST = 11.74

***** SUMMARY INFO FOR PLAN N = 8 L = 2.95 H = 1.600 *****

HOURLY COSTS: ECL = 101.68 HOURS

% OF TIME UP & IN CONTROL: 98.35

NONCONFORMING ITEMS 10.8739 ALPHA = 0.003

FALSE ALARMS 0.0969 P = 0.902

ASSIGNABLE CAUSES 0.0197 ATS = 1.774 HOURS

SAMPLING 0.7454

TOTAL 11.7359

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.50 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 9 L = 3.00 H = 1.700 COST = 11.80

***** SUMMARY INFO FOR PLAN N = 9 L = 3.00 H = 1.700 *****

HOURLY COSTS: ECL = 101.68 HOURS

% OF TIME UP & IN CONTROL: 98.35

NONCONFORMING ITEMS 10.8813 ALPHA = 0.003

FALSE ALARMS 0.0774 P = 0.933

ASSIGNABLE CAUSES 0.0197 ATS = 1.822 HOURS

SAMPLING 0.8185

TOTAL 11.7970

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.60 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 9 L= 3.00 H= 1.800 COST= 11.85

***** SUMMARY INFO FOR PLAN N= 9 L= 3.00 H= 1.800 *****

HOURLY COSTS: ECL = 101.74 HOURS

% OF TIME UP & IN CONTROL: 98.29

NONCONFORMING ITEMS 10.9317 ALPHA = 0.003

FALSE ALARMS 0.0731 P = 0.933

ASSIGNABLE CAUSES 0.0197 ATS = 1.929 HOURS

SAMPLING 0.8283

TOTAL 11.8528

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.70 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 9 L= 3.00 H= 1.900 COST= 11.91

***** SUMMARY INFO FOR PLAN N= 9 L= 3.00 H= 1.900 *****

HOURLY COSTS: ECL = 101.79 HOURS

% OF TIME UP & IN CONTROL: 98.24

NONCONFORMING ITEMS 10.9821 ALPHA = 0.003

FALSE ALARMS 0.0691 P = 0.933

ASSIGNABLE CAUSES 0.0196 ATS = 2.036 HOURS

SAMPLING 0.8370

TOTAL 11.9079

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.80 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 9 L= 3.00 H= 1.900 COST= 11.96

***** SUMMARY INFO FOR PLAN N= 9 L= 3.00 H= 1.900 *****

HOURLY COSTS: ECL = 101.79 HOURS

% OF TIME UP & IN CONTROL: 98.24

NONCONFORMING ITEMS 10.9821 ALPHA = 0.003

FALSE ALARMS 0.0691 P = 0.933

ASSIGNABLE CAUSES 0.0196 ATS = 2.036 HOURS

SAMPLING 0.8893

TOTAL 11.9602

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.90 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 9 L = 2.95 H = 2.000 COST = 12.01

***** SUMMARY INFO FOR PLAN N = 9 L = 2.95 H = 2.000 *****

HOURLY COSTS: ECL = 101.84 HOURS

% OF TIME UP & IN CONTROL: 98.20

NONCONFORMING ITEMS 11.0197 ALPHA = 0.003

FALSE ALARMS 0.0772 P = 0.939

ASSIGNABLE CAUSES 0.0196 ATS = 2.129 HOURS

SAMPLING 0.8946

TOTAL 12.0112

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 9 L = 2.95 H = 2.000 COST = 12.06

***** SUMMARY INFO FOR PLAN N = 9 L = 2.95 H = 2.000 *****

HOURLY COSTS: ECL = 101.84 HOURS

% OF TIME UP & IN CONTROL: 98.20

NONCONFORMING ITEMS 11.0197 ALPHA = 0.003

FALSE ALARMS 0.0772 P = 0.939

ASSIGNABLE CAUSES 0.0196 ATS = 2.129 HOURS

SAMPLING 0.9443

TOTAL 12.0609

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 9 L = 2.95 H = 2.100 COST = 12.11

***** SUMMARY INFO FOR PLAN N = 9 L = 2.95 H = 2.100 *****

HOURLY COSTS: ECL = 101.89 HOURS

% OF TIME UP & IN CONTROL: 98.14

NONCONFORMING ITEMS 11.0694 ALPHA = 0.003

FALSE ALARMS 0.0735 P = 0.939

ASSIGNABLE CAUSES 0.0196 ATS = 2.235 HOURS

SAMPLING 0.9466

TOTAL 12.1092

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 50.00
W = 2.00 A = 1.20 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 9 L= 2.95 H= 2.100 COST= 12.16
***** SUMMARY INFO FOR PLAN N= 9 L = 2.95 H = 2.100 *****
HOURLY COSTS: ECL = 101.89 HOURS

% OF TIME UP & IN CONTROL: 98.14

NONCONFORMING ITEMS	11.0694	ALPHA = 0.003
FALSE ALARMS	0.0735	P = 0.939
ASSIGNABLE CAUSES	0.0196	ATS = 2.235 HOURS
SAMPLING	0.9940	
TOTAL	12.1565	

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 50.00
W = 2.00 A = 1.30 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 9 L= 2.90 H= 2.200 COST= 12.20
***** SUMMARY INFO FOR PLAN N= 9 L = 2.90 H = 2.200 *****
HOURLY COSTS: ECL = 101.94 HOURS

% OF TIME UP & IN CONTROL: 98.10

NONCONFORMING ITEMS	11.1063	ALPHA = 0.004
FALSE ALARMS	0.0823	P = 0.945
ASSIGNABLE CAUSES	0.0196	ATS = 2.328 HOURS
SAMPLING	0.9939	
TOTAL	12.2022	

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 50.00
W = 2.00 A = 1.40 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 10 L= 3.00 H= 2.300 COST= 12.25
***** SUMMARY INFO FOR PLAN N= 10 L = 3.00 H = 2.300 *****
HOURLY COSTS: ECL = 101.96 HOURS

% OF TIME UP & IN CONTROL: 98.07

NONCONFORMING ITEMS	11.1332	ALPHA = 0.003
FALSE ALARMS	0.0569	P = 0.959
ASSIGNABLE CAUSES	0.0196	ATS = 2.397 HOURS
SAMPLING	1.0372	
TOTAL	12.2470	

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.50 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 3.00 H= 2.300 COST= 12.29

***** SUMMARY INFO FOR PLAN N= 10 L = 3.00 H = 2.300 *****

HOURLY COSTS: ECL = 101.96 HOURS

% OF TIME UP & IN CONTROL: 98.07

NONCONFORMING ITEMS 11.1332 ALPHA = 0.003

FALSE ALARMS 0.0569 P = 0.959

ASSIGNABLE CAUSES 0.0196 ATS = 2.397 HOURS

SAMPLING 1.0804

TOTAL 12.2902

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.60 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.400 COST= 12.33

***** SUMMARY INFO FOR PLAN N= 10 L = 2.95 H = 2.400 *****

HOURLY COSTS: ECL = 102.01 HOURS

% OF TIME UP & IN CONTROL: 98.03

NONCONFORMING ITEMS 11.1712 ALPHA = 0.003

FALSE ALARMS 0.0641 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.491 HOURS

SAMPLING 1.0768

TOTAL 12.3318

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.70 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.500 COST= 12.37

***** SUMMARY INFO FOR PLAN N= 10 L = 2.95 H = 2.500 *****

HOURLY COSTS: ECL = 102.06 HOURS

% OF TIME UP & IN CONTROL: 97.98

NONCONFORMING ITEMS 11.2184 ALPHA = 0.003

FALSE ALARMS 0.0615 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.595 HOURS

SAMPLING 1.0735

TOTAL 12.3730

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.80 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.500 COST= 12.41

***** SUMMARY INFO FOR PLAN N= 10 L = 2.95 H = 2.500 *****

HOURLY COSTS: ECL = 102.06 HOURS

% OF TIME UP & IN CONTROL: 97.98

NONCONFORMING ITEMS 11.2184 ALPHA = 0.003

FALSE ALARMS 0.0615 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.595 HOURS

SAMPLING 1.1133

TOTAL 12.4128

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 1.90 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.500 COST= 12.45

***** SUMMARY INFO FOR PLAN N= 10 L = 2.95 H = 2.500 *****

HOURLY COSTS: ECL = 102.06 HOURS

% OF TIME UP & IN CONTROL: 97.98

NONCONFORMING ITEMS 11.2184 ALPHA = 0.003

FALSE ALARMS 0.0615 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.595 HOURS

SAMPLING 1.1530

TOTAL 12.4526

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.600 COST= 12.49

***** SUMMARY INFO FOR PLAN N= 10 L = 2.95 H = 2.600 *****

HOURLY COSTS: ECL = 102.12 HOURS

% OF TIME UP & IN CONTROL: 97.93

NONCONFORMING ITEMS 11.2656 ALPHA = 0.003

FALSE ALARMS 0.0591 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.698 HOURS

SAMPLING 1.1469

TOTAL 12.4912

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.600 COST= 12.53

***** SUMMARY INFO FOR PLAN N= 10 L= 2.95 H= 2.600 *****

HOURLY COSTS: ECL = 102.12 HOURS

% OF TIME UP & IN CONTROL: 97.93

NONCONFORMING ITEMS 11.2656 ALPHA = 0.003

FALSE ALARMS 0.0591 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.698 HOURS

SAMPLING 1.1852

TOTAL 12.5294

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.20 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.700 COST= 12.57

***** SUMMARY INFO FOR PLAN N= 10 L= 2.95 H= 2.700 *****

HOURLY COSTS: ECL = 102.17 HOURS

% OF TIME UP & IN CONTROL: 97.88

NONCONFORMING ITEMS 11.3128 ALPHA = 0.003

FALSE ALARMS 0.0568 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.802 HOURS

SAMPLING 1.1781

TOTAL 12.5672

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.30 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.95 H= 2.700 COST= 12.60

***** SUMMARY INFO FOR PLAN N= 10 L= 2.95 H= 2.700 *****

HOURLY COSTS: ECL = 102.17 HOURS

% OF TIME UP & IN CONTROL: 97.88

NONCONFORMING ITEMS 11.3128 ALPHA = 0.003

FALSE ALARMS 0.0568 P = 0.964

ASSIGNABLE CAUSES 0.0196 ATS = 2.802 HOURS

SAMPLING 1.2149

TOTAL 12.6041

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.40 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 2.800 COST= 12.64

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 2.800 *****

HOURLY COSTS: ECL = 102.21 HOURS

% OF TIME UP & IN CONTROL: 97.83

NONCONFORMING ITEMS 11.3497 ALPHA = 0.004

FALSE ALARMS 0.0643 P = 0.967

ASSIGNABLE CAUSES 0.0196 ATS = 2.894 HOURS

SAMPLING 1.2070

TOTAL 12.6405

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.50 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 2.800 COST= 12.68

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 2.800 *****

HOURLY COSTS: ECL = 102.21 HOURS

% OF TIME UP & IN CONTROL: 97.83

NONCONFORMING ITEMS 11.3497 ALPHA = 0.004

FALSE ALARMS 0.0643 P = 0.967

ASSIGNABLE CAUSES 0.0196 ATS = 2.894 HOURS

SAMPLING 1.2425

TOTAL 12.6760

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.60 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 2.800 COST= 12.71

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 2.800 *****

HOURLY COSTS: ECL = 102.21 HOURS

% OF TIME UP & IN CONTROL: 97.83

NONCONFORMING ITEMS 11.3497 ALPHA = 0.004

FALSE ALARMS 0.0643 P = 0.967

ASSIGNABLE CAUSES 0.0196 ATS = 2.894 HOURS

SAMPLING 1.2780

TOTAL 12.7115

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.70 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 2.900 COST= 12.75

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 2.900 *****

HOURLY COSTS: ECL = 102.27 HOURS

% OF TIME UP & IN CONTROL: 97.78

NONCONFORMING ITEMS 11.3964 ALPHA = 0.004

FALSE ALARMS 0.0620 P = 0.967

ASSIGNABLE CAUSES 0.0196 ATS = 2.998 HOURS

SAMPLING 1.2682

TOTAL 12.7462

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.80 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 2.900 COST= 12.78

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 2.900 *****

HOURLY COSTS: ECL = 102.27 HOURS

% OF TIME UP & IN CONTROL: 97.78

NONCONFORMING ITEMS 11.3964 ALPHA = 0.004

FALSE ALARMS 0.0620 P = 0.967

ASSIGNABLE CAUSES 0.0196 ATS = 2.998 HOURS

SAMPLING 1.3025

TOTAL 12.7805

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 2.90 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 2.900 COST= 12.81

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 2.900 *****

HOURLY COSTS: ECL = 102.27 HOURS

% OF TIME UP & IN CONTROL: 97.78

NONCONFORMING ITEMS 11.3964 ALPHA = 0.004

FALSE ALARMS 0.0620 P = 0.967

ASSIGNABLE CAUSES 0.0196 ATS = 2.998 HOURS

SAMPLING 1.3368

TOTAL 12.8148

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 3.000 COST= 12.85

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 3.000 *****

HOURLY COSTS: ECL = 102.32 HOURS

% OF TIME UP & IN CONTROL: 97.73

NONCONFORMING ITEMS 11.4431 ALPHA = 0.004

FALSE ALARMS 0.0599 P = 0.967

ASSIGNABLE CAUSES 0.0195 ATS = 3.101 HOURS

SAMPLING 1.3254

TOTAL 12.8479

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.90 H= 3.000 COST= 12.88

***** SUMMARY INFO FOR PLAN N= 10 L = 2.90 H = 3.000 *****

HOURLY COSTS: ECL = 102.32 HOURS

% OF TIME UP & IN CONTROL: 97.73

NONCONFORMING ITEMS 11.4431 ALPHA = 0.004

FALSE ALARMS 0.0599 P = 0.967

ASSIGNABLE CAUSES 0.0195 ATS = 3.101 HOURS

SAMPLING 1.3585

TOTAL 12.8810

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.20 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.85 H= 3.100 COST= 12.91

***** SUMMARY INFO FOR PLAN N= 10 L = 2.85 H = 3.100 *****

HOURLY COSTS: ECL = 102.36 HOURS

% OF TIME UP & IN CONTROL: 97.69

NONCONFORMING ITEMS 11.4796 ALPHA = 0.004

FALSE ALARMS 0.0678 P = 0.971

ASSIGNABLE CAUSES 0.0195 ATS = 3.193 HOURS

SAMPLING 1.3467

TOTAL 12.9137

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.30 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 10 L= 2.85 H= 3.100 COST= 12.95

***** SUMMARY INFO FOR PLAN N= 10 L= 2.85 H= 3.100 *****

HOURLY COSTS: ECL = 102.36 HOURS

% OF TIME UP & IN CONTROL: 97.69

NONCONFORMING ITEMS 11.4796 ALPHA = 0.004

FALSE ALARMS 0.0678 P = 0.971

ASSIGNABLE CAUSES 0.0195 ATS = 3.193 HOURS

SAMPLING 1.3788

TOTAL 12.9457

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.40 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.200 COST= 12.98

***** SUMMARY INFO FOR PLAN N= 11 L= 2.95 H= 3.200 *****

HOURLY COSTS: ECL = 102.40 HOURS

% OF TIME UP & IN CONTROL: 97.66

NONCONFORMING ITEMS 11.5125 ALPHA = 0.003

FALSE ALARMS 0.0477 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.270 HOURS

SAMPLING 1.3979

TOTAL 12.9776

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.50 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.200 COST= 13.01

***** SUMMARY INFO FOR PLAN N= 11 L= 2.95 H= 3.200 *****

HOURLY COSTS: ECL = 102.40 HOURS

% OF TIME UP & IN CONTROL: 97.66

NONCONFORMING ITEMS 11.5125 ALPHA = 0.003

FALSE ALARMS 0.0477 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.270 HOURS

SAMPLING 1.4289

TOTAL 13.0087

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.60 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.300 COST= 13.04

***** SUMMARY INFO FOR PLAN N= 11 L= 2.95 H= 3.300 *****

HOURLY COSTS: ECL = 102.45 HOURS

% OF TIME UP & IN CONTROL: 97.61

NONCONFORMING ITEMS 11.5581 ALPHA = 0.003

FALSE ALARMS 0.0462 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.372 HOURS

SAMPLING 1.4158

TOTAL 13.0396

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.70 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.300 COST= 13.07

***** SUMMARY INFO FOR PLAN N= 11 L= 2.95 H= 3.300 *****

HOURLY COSTS: ECL = 102.45 HOURS

% OF TIME UP & IN CONTROL: 97.61

NONCONFORMING ITEMS 11.5581 ALPHA = 0.003

FALSE ALARMS 0.0462 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.372 HOURS

SAMPLING 1.4459

TOTAL 13.0697

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.80 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.300 COST= 13.10

***** SUMMARY INFO FOR PLAN N= 11 L= 2.95 H= 3.300 *****

HOURLY COSTS: ECL = 102.45 HOURS

% OF TIME UP & IN CONTROL: 97.61

NONCONFORMING ITEMS 11.5581 ALPHA = 0.003

FALSE ALARMS 0.0462 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.372 HOURS

SAMPLING 1.4760

TOTAL 13.0999

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 3.90 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.400 COST= 13.13

***** SUMMARY INFO FOR PLAN N= 11 L = 2.95 H = 3.400 *****

HOURLY COSTS: ECL = 102.50 HOURS

% OF TIME UP & IN CONTROL: 97.56

NONCONFORMING ITEMS 11.6036 ALPHA = 0.003

FALSE ALARMS 0.0448 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.474 HOURS

SAMPLING 1.4618

TOTAL 13.1298

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.95 H= 3.400 COST= 13.16

***** SUMMARY INFO FOR PLAN N= 11 L = 2.95 H = 3.400 *****

HOURLY COSTS: ECL = 102.50 HOURS

% OF TIME UP & IN CONTROL: 97.56

NONCONFORMING ITEMS 11.6036 ALPHA = 0.003

FALSE ALARMS 0.0448 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.474 HOURS

SAMPLING 1.4911

TOTAL 13.1591

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

***** SUMMARY INFO FOR PLAN N= 11 L = 2.95 H = 3.400 *****

HOURLY COSTS: ECL = 102.50 HOURS

% OF TIME UP & IN CONTROL: 97.56

NONCONFORMING ITEMS 11.6036 ALPHA = 0.003

FALSE ALARMS 0.0448 P = 0.979

ASSIGNABLE CAUSES 0.0195 ATS = 3.474 HOURS

SAMPLING 1.5203

TOTAL 13.1883

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.20 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.90 H = 3.500 COST = 13.22

***** SUMMARY INFO FOR PLAN N = 11 L = 2.90 H = 3.500 *****

HOURLY COSTS: ECL = 102.55 HOURS

% OF TIME UP & IN CONTROL: 97.51

NONCONFORMING ITEMS 11.6413 ALPHA = 0.004

FALSE ALARMS 0.0511 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.568 HOURS

SAMPLING 1.5053

TOTAL 13.2172

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.30 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.90 H = 3.500 COST = 13.25

***** SUMMARY INFO FOR PLAN N = 11 L = 2.90 H = 3.500 *****

HOURLY COSTS: ECL = 102.55 HOURS

% OF TIME UP & IN CONTROL: 97.51

NONCONFORMING ITEMS 11.6413 ALPHA = 0.004

FALSE ALARMS 0.0511 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.568 HOURS

SAMPLING 1.5337

TOTAL 13.2456

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.40 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.90 H = 3.500 COST = 13.27

***** SUMMARY INFO FOR PLAN N = 11 L = 2.90 H = 3.500 *****

HOURLY COSTS: ECL = 102.55 HOURS

% OF TIME UP & IN CONTROL: 97.51

NONCONFORMING ITEMS 11.6413 ALPHA = 0.004

FALSE ALARMS 0.0511 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.568 HOURS

SAMPLING 1.5621

TOTAL 13.2740

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.50 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.600 COST= 13.30

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.600 *****

HOURLY COSTS: ECL = 102.60 HOURS

% OF TIME UP & IN CONTROL: 97.47

NONCONFORMING ITEMS 11.6866 ALPHA = 0.004

FALSE ALARMS 0.0496 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.670 HOURS

SAMPLING 1.5463

TOTAL 13.3020

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.60 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.600 COST= 13.33

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.600 *****

HOURLY COSTS: ECL = 102.60 HOURS

% OF TIME UP & IN CONTROL: 97.47

NONCONFORMING ITEMS 11.6866 ALPHA = 0.004

FALSE ALARMS 0.0496 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.670 HOURS

SAMPLING 1.5739

TOTAL 13.3296

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.70 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.600 COST= 13.36

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.600 *****

HOURLY COSTS: ECL = 102.60 HOURS

% OF TIME UP & IN CONTROL: 97.47

NONCONFORMING ITEMS 11.6866 ALPHA = 0.004

FALSE ALARMS 0.0496 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.670 HOURS

SAMPLING 1.6015

TOTAL 13.3572

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.80 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.700 COST= 13.38

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.700 *****

HOURLY COSTS: ECL = 102.65 HOURS

% OF TIME UP & IN CONTROL: 97.42

NONCONFORMING ITEMS 11.7318 ALPHA = 0.004

FALSE ALARMS 0.0482 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.772 HOURS

SAMPLING 1.5851

TOTAL 13.3846

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 4.90 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.700 COST= 13.41

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.700 *****

HOURLY COSTS: ECL = 102.65 HOURS

% OF TIME UP & IN CONTROL: 97.42

NONCONFORMING ITEMS 11.7318 ALPHA = 0.004

FALSE ALARMS 0.0482 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.772 HOURS

SAMPLING 1.6120

TOTAL 13.4115

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.700 COST= 13.44

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.700 *****

HOURLY COSTS: ECL = 102.65 HOURS

% OF TIME UP & IN CONTROL: 97.42

NONCONFORMING ITEMS 11.7318 ALPHA = 0.004

FALSE ALARMS 0.0482 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.772 HOURS

SAMPLING 1.6389

TOTAL 13.4384

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.90 H = 3.700 COST = 13.47

***** SUMMARY INFO FOR PLAN N = 11 L = 2.90 H = 3.700 *****

HOURLY COSTS: ECL = 102.65 HOURS

% OF TIME UP & IN CONTROL: 97.42

NONCONFORMING ITEMS 11.7318 ALPHA = 0.004

FALSE ALARMS 0.0482 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.772 HOURS

SAMPLING 1.6657

TOTAL 13.4652

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.20 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.90 H = 3.800 COST = 13.49

***** SUMMARY INFO FOR PLAN N = 11 L = 2.90 H = 3.800 *****

HOURLY COSTS: ECL = 102.71 HOURS

% OF TIME UP & IN CONTROL: 97.37

NONCONFORMING ITEMS 11.7770 ALPHA = 0.004

FALSE ALARMS 0.0469 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.874 HOURS

SAMPLING 1.6481

TOTAL 13.4915

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.30 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.90 H = 3.800 COST = 13.52

***** SUMMARY INFO FOR PLAN N = 11 L = 2.90 H = 3.800 *****

HOURLY COSTS: ECL = 102.71 HOURS

% OF TIME UP & IN CONTROL: 97.37

NONCONFORMING ITEMS 11.7770 ALPHA = 0.004

FALSE ALARMS 0.0469 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.874 HOURS

SAMPLING 1.6742

TOTAL 13.5176

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.40 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.90 H= 3.800 COST= 13.54

***** SUMMARY INFO FOR PLAN N= 11 L = 2.90 H = 3.800 *****

HOURLY COSTS: ECL = 102.71 HOURS

% OF TIME UP & IN CONTROL: 97.37

NONCONFORMING ITEMS 11.7770 ALPHA = 0.004

FALSE ALARMS 0.0469 P = 0.981

ASSIGNABLE CAUSES 0.0195 ATS = 3.874 HOURS

SAMPLING 1.7004

TOTAL 13.5438

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.50 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.85 H= 3.900 COST= 13.57

***** SUMMARY INFO FOR PLAN N= 11 L = 2.85 H = 3.900 *****

HOURLY COSTS: ECL = 102.75 HOURS

% OF TIME UP & IN CONTROL: 97.32

NONCONFORMING ITEMS 11.8144 ALPHA = 0.004

FALSE ALARMS 0.0535 P = 0.983

ASSIGNABLE CAUSES 0.0195 ATS = 3.967 HOURS

SAMPLING 1.6822

TOTAL 13.5696

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.60 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.85 H= 3.900 COST= 13.60

***** SUMMARY INFO FOR PLAN N= 11 L = 2.85 H = 3.900 *****

HOURLY COSTS: ECL = 102.75 HOURS

% OF TIME UP & IN CONTROL: 97.32

NONCONFORMING ITEMS 11.8144 ALPHA = 0.004

FALSE ALARMS 0.0535 P = 0.983

ASSIGNABLE CAUSES 0.0195 ATS = 3.967 HOURS

SAMPLING 1.7077

TOTAL 13.5951

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.70 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.85 H = 3.900 COST = 13.62

***** SUMMARY INFO FOR PLAN N = 11 L = 2.85 H = 3.900 *****

HOURLY COSTS: ECL = 102.75 HOURS

% OF TIME UP & IN CONTROL: 97.32

NONCONFORMING ITEMS 11.8144 ALPHA = 0.004

FALSE ALARMS 0.0535 P = 0.983

ASSIGNABLE CAUSES 0.0195 ATS = 3.967 HOURS

SAMPLING 1.7332

TOTAL 13.6205

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.80 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.85 H = 4.000 COST = 13.65

***** SUMMARY INFO FOR PLAN N = 11 L = 2.85 H = 4.000 *****

HOURLY COSTS: ECL = 102.80 HOURS

% OF TIME UP & IN CONTROL: 97.27

NONCONFORMING ITEMS 11.8593 ALPHA = 0.004

FALSE ALARMS 0.0521 P = 0.983

ASSIGNABLE CAUSES 0.0195 ATS = 4.068 HOURS

SAMPLING 1.7148

TOTAL 13.6456

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 5.90 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.85 H = 4.000 COST = 13.67

***** SUMMARY INFO FOR PLAN N = 11 L = 2.85 H = 4.000 *****

HOURLY COSTS: ECL = 102.80 HOURS

% OF TIME UP & IN CONTROL: 97.27

NONCONFORMING ITEMS 11.8593 ALPHA = 0.004

FALSE ALARMS 0.0521 P = 0.983

ASSIGNABLE CAUSES 0.0195 ATS = 4.068 HOURS

SAMPLING 1.7396

TOTAL 13.6705

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 6.00 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.85 H= 4.000 COST= 13.70

***** SUMMARY INFO FOR PLAN N= 11 L= 2.85 H= 4.000 *****

HOURLY COSTS: ECL = 102.80 HOURS

% OF TIME UP & IN CONTROL: 97.27

NONCONFORMING ITEMS 11.8593 ALPHA = 0.004

FALSE ALARMS 0.0521 P = 0.983

ASSIGNABLE CAUSES 0.0195 ATS = 4.068 HOURS

SAMPLING 1.7645

TOTAL 13.6953

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 6.10 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.85 H= 4.100 COST= 13.72

***** SUMMARY INFO FOR PLAN N= 11 L= 2.85 H= 4.100 *****

HOURLY COSTS: ECL = 102.85 HOURS

% OF TIME UP & IN CONTROL: 97.22

NONCONFORMING ITEMS 11.9042 ALPHA = 0.004

FALSE ALARMS 0.0508 P = 0.983

ASSIGNABLE CAUSES 0.0194 ATS = 4.170 HOURS

SAMPLING 1.7457

TOTAL 13.7201

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 6.20 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 11 L= 2.85 H= 4.100 COST= 13.74

***** SUMMARY INFO FOR PLAN N= 11 L= 2.85 H= 4.100 *****

HOURLY COSTS: ECL = 102.85 HOURS

% OF TIME UP & IN CONTROL: 97.22

NONCONFORMING ITEMS 11.9042 ALPHA = 0.004

FALSE ALARMS 0.0508 P = 0.983

ASSIGNABLE CAUSES 0.0194 ATS = 4.170 HOURS

SAMPLING 1.7699

TOTAL 13.7444

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 6.30 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 11 L = 2.85 H = 4.100 COST = 13.77

***** SUMMARY INFO FOR PLAN N = 11 L = 2.85 H = 4.100 *****

HOURLY COSTS: ECL = 102.85 HOURS

% OF TIME UP & IN CONTROL: 97.22

NONCONFORMING ITEMS 11.9042 ALPHA = 0.004

FALSE ALARMS 0.0508 P = 0.983

ASSIGNABLE CAUSES 0.0194 ATS = 4.170 HOURS

SAMPLING 1.7942

TOTAL 13.7686

3.2 Perubahan b (variable cost)

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 11.46

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4638

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.85 H = 1.700 COST = 11.95

***** SUMMARY INFO FOR PLAN N = 7 L = 2.85 H = 1.700 *****

HOURLY COSTS: ECL = 101.81 HOURS

% OF TIME UP & IN CONTROL: 98.23

NONCONFORMING ITEMS 10.9819 ALPHA = 0.004

FALSE ALARMS 0.1252 P = 0.868

ASSIGNABLE CAUSES 0.0196 ATS = 1.958 HOURS

SAMPLING 0.8243

TOTAL 11.9510

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.65 H= 1.900 COST= 12.31

***** SUMMARY INFO FOR PLAN N= 6 L= 2.65 H= 1.900 *****

HOURLY COSTS: ECL = 102.00 HOURS

% OF TIME UP & IN CONTROL: 98.04

NONCONFORMING ITEMS 11.1334 ALPHA = 0.008

FALSE ALARMS 0.2057 P = 0.847

ASSIGNABLE CAUSES 0.0196 ATS = 2.243 HOURS

SAMPLING 0.9466

TOTAL 12.3054

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.40

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.60 H= 2.200 COST= 12.59

***** SUMMARY INFO FOR PLAN N= 6 L= 2.60 H= 2.200 *****

HOURLY COSTS: ECL = 102.17 HOURS

% OF TIME UP & IN CONTROL: 97.88

NONCONFORMING ITEMS 11.2816 ALPHA = 0.009

FALSE ALARMS 0.2051 P = 0.859

ASSIGNABLE CAUSES 0.0196 ATS = 2.562 HOURS

SAMPLING 1.0886

TOTAL 12.5949

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.50

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.55 H= 2.500 COST= 12.85

***** SUMMARY INFO FOR PLAN N= 6 L= 2.55 H= 2.500 *****

HOURLY COSTS: ECL = 102.33 HOURS

% OF TIME UP & IN CONTROL: 97.72

NONCONFORMING ITEMS 11.4238 ALPHA = 0.011

FALSE ALARMS 0.2079 P = 0.870

ASSIGNABLE CAUSES 0.0195 ATS = 2.875 HOURS

SAMPLING 1.1964

TOTAL 12.8477

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ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.60

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 5 L= 2.40 H= 2.500 COST= 13.06

***** SUMMARY INFO FOR PLAN N= 5 L= 2.40 H= 2.500 *****

HOURLY COSTS: ECL = 102.48 HOURS

% OF TIME UP & IN CONTROL: 97.58

NONCONFORMING ITEMS 11.5311 ALPHA = 0.016

FALSE ALARMS 0.3160 P = 0.830

ASSIGNABLE CAUSES 0.0195 ATS = 3.012 HOURS

SAMPLING 1.1962

TOTAL 13.0628

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.70

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 5 L= 2.40 H= 2.600 COST= 13.26

***** SUMMARY INFO FOR PLAN N= 5 L= 2.40 H= 2.600 *****

HOURLY COSTS: ECL = 102.55 HOURS

% OF TIME UP & IN CONTROL: 97.51

NONCONFORMING ITEMS 11.5926 ALPHA = 0.016

FALSE ALARMS 0.3035 P = 0.830

ASSIGNABLE CAUSES 0.0195 ATS = 3.133 HOURS

SAMPLING 1.3413

TOTAL 13.2568

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.80

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 5 L= 2.35 H= 2.900 COST= 13.44

***** SUMMARY INFO FOR PLAN N= 5 L= 2.35 H= 2.900 *****

HOURLY COSTS: ECL = 102.71 HOURS

% OF TIME UP & IN CONTROL: 97.36

NONCONFORMING ITEMS 11.7315 ALPHA = 0.019

FALSE ALARMS 0.3106 P = 0.842

ASSIGNABLE CAUSES 0.0195 ATS = 3.443 HOURS

SAMPLING 1.3738

TOTAL 13.4353

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.90

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 5 L= 2.30 H= 3.100 COST= 13.60

***** SUMMARY INFO FOR PLAN N= 5 L= 2.30 H= 3.100 *****

HOURLY COSTS: ECL = 102.81 HOURS

% OF TIME UP & IN CONTROL: 97.27

NONCONFORMING ITEMS 11.8064 ALPHA = 0.021

FALSE ALARMS 0.3313 P = 0.854

ASSIGNABLE CAUSES 0.0195 ATS = 3.630 HOURS

SAMPLING 1.4454

TOTAL 13.6025

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 5 L= 2.25 H= 3.400 COST= 13.91

***** SUMMARY INFO FOR PLAN N= 5 L= 2.25 H= 3.400 *****

HOURLY COSTS: ECL = 102.96 HOURS

% OF TIME UP & IN CONTROL: 97.13

NONCONFORMING ITEMS 11.9359 ALPHA = 0.024

FALSE ALARMS 0.3433 P = 0.865

ASSIGNABLE CAUSES 0.0194 ATS = 3.930 HOURS

SAMPLING 1.6100

TOTAL 13.9087

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 4 L= 2.15 H= 3.100 COST= 14.04

***** SUMMARY INFO FOR PLAN N= 4 L= 2.15 H= 3.100 *****

HOURLY COSTS: ECL = 103.06 HOURS

% OF TIME UP & IN CONTROL: 97.03

NONCONFORMING ITEMS 11.9945 ALPHA = 0.032

FALSE ALARMS 0.4862 P = 0.802

ASSIGNABLE CAUSES 0.0194 ATS = 3.864 HOURS

SAMPLING 1.5411

TOTAL 14.0411

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 4 L= 2.15 H= 3.200 COST= 14.17

***** SUMMARY INFO FOR PLAN N= 4 L= 2.15 H= 3.200 *****

HOURLY COSTS: ECL = 103.13 HOURS

% OF TIME UP & IN CONTROL: 96.96

NONCONFORMING ITEMS 12.0590 ALPHA = 0.032

FALSE ALARMS 0.4705 P = 0.802

ASSIGNABLE CAUSES 0.0194 ATS = 3.988 HOURS

SAMPLING 1.6171

TOTAL 14.1659

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.40

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 4 L= 2.10 H= 3.400 COST= 14.28

***** SUMMARY INFO FOR PLAN N= 4 L= 2.10 H= 3.400 *****

HOURLY COSTS: ECL = 103.22 HOURS

% OF TIME UP & IN CONTROL: 96.88

NONCONFORMING ITEMS 12.1262 ALPHA = 0.036

FALSE ALARMS 0.5004 P = 0.816

ASSIGNABLE CAUSES 0.0194 ATS = 4.167 HOURS

SAMPLING 1.6388

TOTAL 14.2847

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.50

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 4 L= 2.10 H= 3.500 COST= 14.40

***** SUMMARY INFO FOR PLAN N= 4 L= 2.10 H= 3.500 *****

HOURLY COSTS: ECL = 103.29 HOURS

% OF TIME UP & IN CONTROL: 96.81

NONCONFORMING ITEMS 12.1887 ALPHA = 0.036

FALSE ALARMS 0.4856 P = 0.816

ASSIGNABLE CAUSES 0.0194 ATS = 4.290 HOURS

SAMPLING 1.7055

TOTAL 14.3991

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.60

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 2.05 H = 3.700 COST = 14.51

***** SUMMARY INFO FOR PLAN N = 4 L = 2.05 H = 3.700 *****

HOURLY COSTS: ECL = 103.37 HOURS

% OF TIME UP & IN CONTROL: 96.74

NONCONFORMING ITEMS 12.2518 ALPHA = 0.040

FALSE ALARMS 0.5180 P = 0.829

ASSIGNABLE CAUSES 0.0193 ATS = 4.464 HOURS

SAMPLING 1.7206

TOTAL 14.5097

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.70

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 2.05 H = 3.800 COST = 14.62

***** SUMMARY INFO FOR PLAN N = 4 L = 2.05 H = 3.800 *****

HOURLY COSTS: ECL = 103.44 HOURS

% OF TIME UP & IN CONTROL: 96.67

NONCONFORMING ITEMS 12.3126 ALPHA = 0.040

FALSE ALARMS 0.5038 P = 0.829

ASSIGNABLE CAUSES 0.0193 ATS = 4.584 HOURS

SAMPLING 1.7799

TOTAL 14.6156

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.80

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 2.05 H = 3.900 COST = 14.72

***** SUMMARY INFO FOR PLAN N = 4 L = 2.05 H = 3.900 *****

HOURLY COSTS: ECL = 103.51 HOURS

% OF TIME UP & IN CONTROL: 96.61

NONCONFORMING ITEMS 12.3733 ALPHA = 0.040

FALSE ALARMS 0.4903 P = 0.829

ASSIGNABLE CAUSES 0.0193 ATS = 4.705 HOURS

SAMPLING 1.8362

TOTAL 14.7191

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.90

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 2.00 H = 4.100 COST = 14.82

***** SUMMARY INFO FOR PLAN N = 4 L = 2.00 H = 4.100 *****

HOURLY COSTS: ECL = 103.59 HOURS

% OF TIME UP & IN CONTROL: 96.54

NONCONFORMING ITEMS 12.4314 ALPHA = 0.046

FALSE ALARMS 0.5248 P = 0.841

ASSIGNABLE CAUSES 0.0193 ATS = 4.873 HOURS

SAMPLING 1.8434

TOTAL 14.8189

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 1.00

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 5 L = 2.30 H = 3.200 COST = 13.76

***** SUMMARY INFO FOR PLAN N = 5 L = 2.30 H = 3.200 *****

HOURLY COSTS: ECL = 102.87 HOURS

% OF TIME UP & IN CONTROL: 97.21

NONCONFORMING ITEMS 11.8646 ALPHA = 0.021

FALSE ALARMS 0.3206 P = 0.854

ASSIGNABLE CAUSES 0.0194 ATS = 3.747 HOURS

SAMPLING 1.5555

TOTAL 13.7601

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 2.00 H = 4.200 COST = 15.01

***** SUMMARY INFO FOR PLAN N = 4 L = 2.00 H = 4.200 *****

HOURLY COSTS: ECL = 103.65 HOURS

% OF TIME UP & IN CONTROL: 96.48

NONCONFORMING ITEMS 12.4905 ALPHA = 0.046

FALSE ALARMS 0.5117 P = 0.841

ASSIGNABLE CAUSES 0.0193 ATS = 4.992 HOURS

SAMPLING 1.9887

TOTAL 15.0102

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 1.95 H = 4.400 COST = 15.10

***** SUMMARY INFO FOR PLAN N = 4 L = 1.95 H = 4.400 *****

HOURLY COSTS: ECL = 103.73 HOURS

% OF TIME UP & IN CONTROL: 96.41

NONCONFORMING ITEMS 12.5459 ALPHA = 0.051

FALSE ALARMS 0.5484 P = 0.853

ASSIGNABLE CAUSES 0.0193 ATS = 5.157 HOURS

SAMPLING 1.9885

TOTAL 15.1021

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 1.95 H = 4.500 COST = 15.19

***** SUMMARY INFO FOR PLAN N = 4 L = 1.95 H = 4.500 *****

HOURLY COSTS: ECL = 103.79 HOURS

% OF TIME UP & IN CONTROL: 96.35

NONCONFORMING ITEMS 12.6035 ALPHA = 0.051

FALSE ALARMS 0.5356 P = 0.853

ASSIGNABLE CAUSES 0.0193 ATS = 5.275 HOURS

SAMPLING 2.0326

TOTAL 15.1910

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.40

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 1.95 H = 4.600 COST = 15.28

***** SUMMARY INFO FOR PLAN N = 4 L = 1.95 H = 4.600 *****

HOURLY COSTS: ECL = 103.86 HOURS

% OF TIME UP & IN CONTROL: 96.29

NONCONFORMING ITEMS 12.6610 ALPHA = 0.051

FALSE ALARMS 0.5234 P = 0.853

ASSIGNABLE CAUSES 0.0193 ATS = 5.392 HOURS

SAMPLING 2.0749

TOTAL 15.2785

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.50

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.85 H= 4.000 COST= 15.35

***** SUMMARY INFO FOR PLAN N= 3 L= 1.85 H= 4.000 *****

HOURLY COSTS: ECL = 103.98 HOURS

% OF TIME UP & IN CONTROL: 96.18

NONCONFORMING ITEMS 12.7137 ALPHA = 0.064

FALSE ALARMS 0.7578 P = 0.773

ASSIGNABLE CAUSES 0.0192 ATS = 5.176 HOURS

SAMPLING 1.8638

TOTAL 15.3546

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.60

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.85 H= 4.000 COST= 15.43

***** SUMMARY INFO FOR PLAN N= 3 L= 1.85 H= 4.000 *****

HOURLY COSTS: ECL = 103.98 HOURS

% OF TIME UP & IN CONTROL: 96.18

NONCONFORMING ITEMS 12.7137 ALPHA = 0.064

FALSE ALARMS 0.7578 P = 0.773

ASSIGNABLE CAUSES 0.0192 ATS = 5.176 HOURS

SAMPLING 1.9383

TOTAL 15.4290

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.70

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.80 H= 4.200 COST= 15.50

***** SUMMARY INFO FOR PLAN N= 3 L= 1.80 H= 4.200 *****

HOURLY COSTS: ECL = 104.04 HOURS

% OF TIME UP & IN CONTROL: 96.11

NONCONFORMING ITEMS 12.7612 ALPHA = 0.072

FALSE ALARMS 0.8051 P = 0.788

ASSIGNABLE CAUSES 0.0192 ATS = 5.333 HOURS

SAMPLING 1.9167

TOTAL 15.5022

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.80

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.80 H = 4.300 COST = 15.57

***** SUMMARY INFO FOR PLAN N = 3 L = 1.80 H = 4.300 *****

HOURLY COSTS: ECL = 104.12 HOURS

% OF TIME UP & IN CONTROL: 96.04

NONCONFORMING ITEMS 12.8268 ALPHA = 0.072

FALSE ALARMS 0.7854 P = 0.788

ASSIGNABLE CAUSES 0.0192 ATS = 5.460 HOURS

SAMPLING 1.9415

TOTAL 15.5729

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.90

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.80 H = 4.300 COST = 15.64

***** SUMMARY INFO FOR PLAN N = 3 L = 1.80 H = 4.300 *****

HOURLY COSTS: ECL = 104.12 HOURS

% OF TIME UP & IN CONTROL: 96.04

NONCONFORMING ITEMS 12.8268 ALPHA = 0.072

FALSE ALARMS 0.7854 P = 0.788

ASSIGNABLE CAUSES 0.0192 ATS = 5.460 HOURS

SAMPLING 2.0107

TOTAL 15.6421

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 2.00

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 4 L = 2.00 H = 4.200 COST = 14.92

***** SUMMARY INFO FOR PLAN N = 4 L = 2.00 H = 4.200 *****

HOURLY COSTS: ECL = 103.65 HOURS

% OF TIME UP & IN CONTROL: 96.48

NONCONFORMING ITEMS 12.4905 ALPHA = 0.046

FALSE ALARMS 0.5117 P = 0.841

ASSIGNABLE CAUSES 0.0193 ATS = 4.992 HOURS

SAMPLING 1 0.8942

TOTAL 14.9156

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.80 H = 4.400 COST = 15.78

***** SUMMARY INFO FOR PLAN N = 3 L = 1.80 H = 4.400 *****

HOURLY COSTS: ECL = 104.19 HOURS

% OF TIME UP & IN CONTROL: 95.98

NONCONFORMING ITEMS 12.8923 ALPHA = 0.072

FALSE ALARMS 0.7666 P = 0.788

ASSIGNABLE CAUSES 0.0192 ATS = 5.587 HOURS

SAMPLING 2.1005

TOTAL 15.7786

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.75 H = 4.600 COST = 15.84

***** SUMMARY INFO FOR PLAN N = 3 L = 1.75 H = 4.600 *****

HOURLY COSTS: ECL = 104.25 HOURS

% OF TIME UP & IN CONTROL: 95.92

NONCONFORMING ITEMS 12.9343 ALPHA = 0.080

FALSE ALARMS 0.8162 P = 0.802

ASSIGNABLE CAUSES 0.0192 ATS = 5.737 HOURS

SAMPLING 2.0737

TOTAL 15.8434

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.75 H = 4.700 COST = 15.91

***** SUMMARY INFO FOR PLAN N = 3 L = 1.75 H = 4.700 *****

HOURLY COSTS: ECL = 104.33 HOURS

% OF TIME UP & IN CONTROL: 95.85

NONCONFORMING ITEMS 12.9978 ALPHA = 0.080

FALSE ALARMS 0.7979 P = 0.802

ASSIGNABLE CAUSES 0.0192 ATS = 5.862 HOURS

SAMPLING 2.0930

TOTAL 15.9079

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.75 H= 4.700 COST= 15.91

***** SUMMARY INFO FOR PLAN N= 3 L = 1.75 H = 4.700 *****

HOURLY COSTS: ECL = 104.33 HOURS

% OF TIME UP & IN CONTROL: 95.85

NONCONFORMING ITEMS 12.9978 ALPHA = 0.080

FALSE ALARMS 0.7979 P = 0.802

ASSIGNABLE CAUSES 0.0192 ATS = 5.862 HOURS

SAMPLING 2.0930

TOTAL 15.9079

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.40

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.75 H= 4.700 COST= 15.97

***** SUMMARY INFO FOR PLAN N= 3 L = 1.75 H = 4.700 *****

HOURLY COSTS: ECL = 104.33 HOURS

% OF TIME UP & IN CONTROL: 95.85

NONCONFORMING ITEMS 12.9978 ALPHA = 0.080

FALSE ALARMS 0.7979 P = 0.802

ASSIGNABLE CAUSES 0.0192 ATS = 5.862 HOURS

SAMPLING 2.1564

TOTAL 15.9713

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.50

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.75 H= 4.800 COST= 16.03

***** SUMMARY INFO FOR PLAN N= 3 L = 1.75 H = 4.800 *****

HOURLY COSTS: ECL = 104.40 HOURS

% OF TIME UP & IN CONTROL: 95.79

NONCONFORMING ITEMS 13.0612 ALPHA = 0.080

FALSE ALARMS 0.7804 P = 0.802

ASSIGNABLE CAUSES 0.0192 ATS = 5.986 HOURS

SAMPLING 2.1736

TOTAL 16.0343

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.60

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.70 H = 5.000 COST = 16.10

***** SUMMARY INFO FOR PLAN N = 3 L = 1.70 H = 5.000 *****

HOURLY COSTS: ECL = 104.46 HOURS

% OF TIME UP & IN CONTROL: 95.73

NONCONFORMING ITEMS 13.0988 ALPHA = 0.089

FALSE ALARMS 0.8321 P = 0.815

ASSIGNABLE CAUSES 0.0191 ATS = 6.132 HOURS

SAMPLING 2.1460

TOTAL 16.0960

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.70

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.70 H = 5.000 COST = 16.16

***** SUMMARY INFO FOR PLAN N = 3 L = 1.70 H = 5.000 *****

HOURLY COSTS: ECL = 104.46 HOURS

% OF TIME UP & IN CONTROL: 95.73

NONCONFORMING ITEMS 13.0988 ALPHA = 0.089

FALSE ALARMS 0.8321 P = 0.815

ASSIGNABLE CAUSES 0.0191 ATS = 6.132 HOURS

SAMPLING 2.2055

TOTAL 16.1556

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 3.90

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.80 H = 4.400 COST = 15.71

***** SUMMARY INFO FOR PLAN N = 3 L = 1.80 H = 4.400 *****

HOURLY COSTS: ECL = 104.19 HOURS

% OF TIME UP & IN CONTROL: 95.98

NONCONFORMING ITEMS 12.8923 ALPHA = 0.072

FALSE ALARMS 0.7666 P = 0.788

ASSIGNABLE CAUSES 0.0192 ATS = 5.587 HOURS

SAMPLING 2.0328

TOTAL 15.7109

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.70 H = 5.200 COST = 16.39

***** SUMMARY INFO FOR PLAN N = 3 L = 1.70 H = 5.200 *****

HOURLY COSTS: ECL = 104.60 HOURS

% OF TIME UP & IN CONTROL: 95.61

NONCONFORMING ITEMS 13.2218 ALPHA = 0.089

FALSE ALARMS 0.7982 P = 0.815

ASSIGNABLE CAUSES 0.0191 ATS = 6.377 HOURS

SAMPLING 2.3499

TOTAL 16.3891

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.65 H = 5.400 COST = 16.44

***** SUMMARY INFO FOR PLAN N = 3 L = 1.65 H = 5.400 *****

HOURLY COSTS: ECL = 104.65 HOURS

% OF TIME UP & IN CONTROL: 95.56

NONCONFORMING ITEMS 13.2559 ALPHA = 0.099

FALSE ALARMS 0.8520 P = 0.828

ASSIGNABLE CAUSES 0.0191 ATS = 6.518 HOURS

SAMPLING 2.3178

TOTAL 16.4448

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.65 H = 5.400 COST = 16.50

***** SUMMARY INFO FOR PLAN N = 3 L = 1.65 H = 5.400 *****

HOURLY COSTS: ECL = 104.65 HOURS

% OF TIME UP & IN CONTROL: 95.56

NONCONFORMING ITEMS 13.2559 ALPHA = 0.099

FALSE ALARMS 0.8520 P = 0.828

ASSIGNABLE CAUSES 0.0191 ATS = 6.518 HOURS

SAMPLING 2.3730

TOTAL 16.5000

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.40

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.65 H = 5.500 COST = 16.55

***** SUMMARY INFO FOR PLAN N = 3 L = 1.65 H = 5.500 *****

HOURLY COSTS: ECL = 104.72 HOURS

% OF TIME UP & IN CONTROL: 95.49

NONCONFORMING ITEMS 13.3156 ALPHA = 0.099

FALSE ALARMS 0.8355 P = 0.828

ASSIGNABLE CAUSES 0.0191 ATS = 6.639 HOURS

SAMPLING 2.3840

TOTAL 16.5543

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.50

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.65 H = 5.500 COST = 16.61

***** SUMMARY INFO FOR PLAN N = 3 L = 1.65 H = 5.500 *****

HOURLY COSTS: ECL = 104.72 HOURS

% OF TIME UP & IN CONTROL: 95.49

NONCONFORMING ITEMS 13.3156 ALPHA = 0.099

FALSE ALARMS 0.8355 P = 0.828

ASSIGNABLE CAUSES 0.0191 ATS = 6.639 HOURS

SAMPLING 2.4382

TOTAL 16.6085

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.60

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.65 H = 5.600 COST = 16.66

***** SUMMARY INFO FOR PLAN N = 3 L = 1.65 H = 5.600 *****

HOURLY COSTS: ECL = 104.79 HOURS

% OF TIME UP & IN CONTROL: 95.43

NONCONFORMING ITEMS 13.3753 ALPHA = 0.099

FALSE ALARMS 0.8197 P = 0.828

ASSIGNABLE CAUSES 0.0191 ATS = 6.759 HOURS

SAMPLING 2.4479

TOTAL 16.6620

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.70

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.65 H= 5.600 COST= 16.72

***** SUMMARY INFO FOR PLAN N= 3 L = 1.65 H = 5.600 *****

HOURLY COSTS: ECL = 104.79 HOURS

% OF TIME UP & IN CONTROL: 95.43

NONCONFORMING ITEMS 13.3753 ALPHA = 0.099

FALSE ALARMS 0.8197 P = 0.828

ASSIGNABLE CAUSES 0.0191 ATS = 6.759 HOURS

SAMPLING 2.5011

TOTAL 16.7151

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.80

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.60 H= 5.800 COST= 16.77

***** SUMMARY INFO FOR PLAN N= 3 L = 1.60 H = 5.800 *****

HOURLY COSTS: ECL = 104.84 HOURS

% OF TIME UP & IN CONTROL: 95.38

NONCONFORMING ITEMS 13.4067 ALPHA = 0.110

FALSE ALARMS 0.8753 P = 0.841

ASSIGNABLE CAUSES 0.0191 ATS = 6.897 HOURS

SAMPLING 2.4659

TOTAL 16.7670

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.90

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.60 H= 5.900 COST= 16.82

***** SUMMARY INFO FOR PLAN N= 3 L = 1.60 H = 5.900 *****

HOURLY COSTS: ECL = 104.91 HOURS

% OF TIME UP & IN CONTROL: 95.32

NONCONFORMING ITEMS 13.4648 ALPHA = 0.110

FALSE ALARMS 0.8595 P = 0.841

ASSIGNABLE CAUSES 0.0191 ATS = 7.016 HOURS

SAMPLING 2.4747

TOTAL 16.8181

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 4.00

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.70 H= 5.200 COST= 16.33

***** SUMMARY INFO FOR PLAN N= 3 L= 1.70 H= 5.200 *****

HOURLY COSTS: ECL = 104.60 HOURS

% OF TIME UP & IN CONTROL: 95.61

NONCONFORMING ITEMS 13.2218 ALPHA = 0.089

FALSE ALARMS 0.7982 P = 0.815

ASSIGNABLE CAUSES 0.0191 ATS = 6.377 HOURS

SAMPLING 2.2927

TOTAL 16.3318

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.60 H= 6.000 COST= 16.92

***** SUMMARY INFO FOR PLAN N= 3 L= 1.60 H= 6.000 *****

HOURLY COSTS: ECL = 104.97 HOURS

% OF TIME UP & IN CONTROL: 95.26

NONCONFORMING ITEMS 13.5229 ALPHA = 0.110

FALSE ALARMS 0.8442 P = 0.841

ASSIGNABLE CAUSES 0.0191 ATS = 7.135 HOURS

SAMPLING 2.5328

TOTAL 16.9189

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 2 L= 1.50 H= 4.800 COST= 16.97

***** SUMMARY INFO FOR PLAN N= 2 L= 1.50 H= 4.800 *****

HOURLY COSTS: ECL = 105.06 HOURS

% OF TIME UP & IN CONTROL: 95.18

NONCONFORMING ITEMS 13.5047 ALPHA = 0.134

FALSE ALARMS 1.2932 P = 0.733

ASSIGNABLE CAUSES 0.0190 ATS = 6.549 HOURS

SAMPLING 2.1508

TOTAL 16.9678

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 2 L = 1.50 H = 4.900 COST = 17.01

***** SUMMARY INFO FOR PLAN N = 2 L = 1.50 H = 4.900 *****

HOURLY COSTS: ECL = 105.14 HOURS

% OF TIME UP & IN CONTROL: 95.11

NONCONFORMING ITEMS 13.5772 ALPHA = 0.134

FALSE ALARMS 1.2652 P = 0.733

ASSIGNABLE CAUSES 0.0190 ATS = 6.685 HOURS

SAMPLING 2.1475

TOTAL 17.0090

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.40

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 2 L = 1.50 H = 4.900 COST = 17.05

***** SUMMARY INFO FOR PLAN N = 2 L = 1.50 H = 4.900 *****

HOURLY COSTS: ECL = 105.14 HOURS

% OF TIME UP & IN CONTROL: 95.11

NONCONFORMING ITEMS 13.5772 ALPHA = 0.134

FALSE ALARMS 1.2652 P = 0.733

ASSIGNABLE CAUSES 0.0190 ATS = 6.685 HOURS

SAMPLING 2.1880

TOTAL 17.0494

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.50

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 2 L = 1.50 H = 4.900 COST = 17.09

***** SUMMARY INFO FOR PLAN N = 2 L = 1.50 H = 4.900 *****

HOURLY COSTS: ECL = 105.14 HOURS

% OF TIME UP & IN CONTROL: 95.11

NONCONFORMING ITEMS 13.5772 ALPHA = 0.134

FALSE ALARMS 1.2652 P = 0.733

ASSIGNABLE CAUSES 0.0190 ATS = 6.685 HOURS

SAMPLING 2.2284

TOTAL 17.0899

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.60

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 2 L = 1.45 H = 5.100 COST = 17.13

***** SUMMARY INFO FOR PLAN N = 2 L = 1.45 H = 5.100 *****

HOURLY COSTS: ECL = 105.18 HOURS

% OF TIME UP & IN CONTROL: 95.07

NONCONFORMING ITEMS 13.5950 ALPHA = 0.147

FALSE ALARMS 1.3361 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 6.808 HOURS

SAMPLING 2.1796

TOTAL 17.1297

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.70

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 2 L = 1.45 H = 5.100 COST = 17.17

***** SUMMARY INFO FOR PLAN N = 2 L = 1.45 H = 5.100 *****

HOURLY COSTS: ECL = 105.18 HOURS

% OF TIME UP & IN CONTROL: 95.07

NONCONFORMING ITEMS 13.5950 ALPHA = 0.147

FALSE ALARMS 1.3361 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 6.808 HOURS

SAMPLING 2.2185

TOTAL 17.1686

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.80

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 2 L = 1.45 H = 5.200 COST = 17.21

***** SUMMARY INFO FOR PLAN N = 2 L = 1.45 H = 5.200 *****

HOURLY COSTS: ECL = 105.26 HOURS

% OF TIME UP & IN CONTROL: 95.00

NONCONFORMING ITEMS 13.6649 ALPHA = 0.147

FALSE ALARMS 1.3088 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 6.941 HOURS

SAMPLING 2.2141

TOTAL 17.2068

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.90

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 2 L= 1.45 H= 5.200 COST= 17.24

***** SUMMARY INFO FOR PLAN N= 2 L= 1.45 H= 5.200 *****

HOURLY COSTS: ECL = 105.26 HOURS

% OF TIME UP & IN CONTROL: 95.00

NONCONFORMING ITEMS 13.6649 ALPHA = 0.147

FALSE ALARMS 1.3088 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 6.941 HOURS

SAMPLING 2.2523

TOTAL 17.2449

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 5.00

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 3 L= 1.60 H= 5.900 COST= 16.87

***** SUMMARY INFO FOR PLAN N= 3 L= 1.60 H= 5.900 *****

HOURLY COSTS: ECL = 104.91 HOURS

% OF TIME UP & IN CONTROL: 95.32

NONCONFORMING ITEMS 13.4648 ALPHA = 0.110

FALSE ALARMS 0.8595 P = 0.841

ASSIGNABLE CAUSES 0.0191 ATS = 7.016 HOURS

SAMPLING 2.5251

TOTAL 16.8685

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 6.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 2 L= 1.45 H= 5.300 COST= 17.32

***** SUMMARY INFO FOR PLAN N= 2 L= 1.45 H= 5.300 *****

HOURLY COSTS: ECL = 105.34 HOURS

% OF TIME UP & IN CONTROL: 94.93

NONCONFORMING ITEMS 13.7347 ALPHA = 0.147

FALSE ALARMS 1.2824 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 7.075 HOURS

SAMPLING 2.2847

TOTAL 17.3209

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 6.20

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 2 L= 1.45 H= 5.300 COST= 17.36

***** SUMMARY INFO FOR PLAN N= 2 L = 1.45 H = 5.300 *****

HOURLY COSTS: ECL = 105.34 HOURS

% OF TIME UP & IN CONTROL: 94.93

NONCONFORMING ITEMS 13.7347 ALPHA = 0.147

FALSE ALARMS 1.2824 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 7.075 HOURS

SAMPLING 2.3222

TOTAL 17.3583

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 6.30

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 2 L= 1.40 H= 5.500 COST= 17.40

***** SUMMARY INFO FOR PLAN N= 2 L = 1.40 H = 5.500 *****

HOURLY COSTS: ECL = 105.37 HOURS

% OF TIME UP & IN CONTROL: 94.90

NONCONFORMING ITEMS 13.7476 ALPHA = 0.162

FALSE ALARMS 1.3555 P = 0.765

ASSIGNABLE CAUSES 0.0190 ATS = 7.191 HOURS

SAMPLING 2.2735

TOTAL 17.3955

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 6.00

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 2 L= 1.45 H= 5.200 COST= 17.28

***** SUMMARY INFO FOR PLAN N= 2 L = 1.45 H = 5.200 *****

HOURLY COSTS: ECL = 105.26 HOURS

% OF TIME UP & IN CONTROL: 95.00

NONCONFORMING ITEMS 13.6649 ALPHA = 0.147

FALSE ALARMS 1.3088 P = 0.749

ASSIGNABLE CAUSES 0.0190 ATS = 6.941 HOURS

SAMPLING 2.2904

TOTAL 17.2831

3.3 Perubahan C₀

ECONOMIC PARAMETER VALUES

E = 0.010 T₀ = 0.100 T₁ = 0.100 T₂ = 0.500

C₀ = 0.00 C₁ = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D₁ = 0 D₂ = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 1.610

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 0.8284 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 1.6099

ECONOMIC PARAMETER VALUES

E = 0.010 T₀ = 0.100 T₁ = 0.100 T₂ = 0.500

C₀ = 0.01 C₁ = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D₁ = 0 D₂ = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 1.620

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 0.8383 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 1.6197

ECONOMIC PARAMETER VALUES

E = 0.010 T₀ = 0.100 T₁ = 0.100 T₂ = 0.500

C₀ = 0.10 C₁ = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D₁ = 0 D₂ = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 1.708

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 0.9270 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 1.7084

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.20 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 1.807

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.0255 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 1.8070

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.30 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 1.906

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.1241 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 1.9055

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.40 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.004

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.2226 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.0041

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.50 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 2.103

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.3212 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.1027

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.60 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 2.201

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.4197 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.2012

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.70 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 2.300

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.5183 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.2998

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.80 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.398

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.6168 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.3983

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 0.90 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.497

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.7154 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.4969

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.10 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.694

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 1.9125 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.6940

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.20 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.793

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.0111 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.7926

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.30 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.891

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.1096 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.8911

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.40 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 2.990

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.2082 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 2.9897

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.50 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 3.088

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.3067 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.0882

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.60 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 3.187

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.4053 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.1868

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.70 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 3.285

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.5039 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.2853

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.80 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.384

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.6024 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.3839

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 1.90 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.482

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.7010 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.4824

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.581

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.7995 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.5810

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.10 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.680

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.8981 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.6796

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.20 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.778

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 2.9966 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.7781

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.30 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.877

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.0952 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.8767

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.40 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 3.975

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.1937 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 3.9752

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.50 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.074

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.2923 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.0738

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.60 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.172

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.3909 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.1723

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.70 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.271

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.4894 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.2709

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.80 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.369

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.5880 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.3695

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 2.90 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.468

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 3.6865 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.4680

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.30 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.862

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.0808 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.8622

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.40 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 4.961

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.1793 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 4.9608

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.50 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 5.039

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.2779 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 5.0393

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.60 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 5.158

***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.3764 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 5.1579

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.70 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 5.256

***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.4750 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 5.2565

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.80 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 5.355

***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.5735 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 5.3550

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 3.90 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 5.454

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.6721 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 5.4536

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 4.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 5.552

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 4.7706 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 5.5521

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 5.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 6.538

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 5.7562 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 6.5377

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 6.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 7.523

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 6.7418 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 7.5233

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 7.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 8.509

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 7.7273 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 8.5088

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 8.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 9.494

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 8.7761 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 9.4940

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 9.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 10.48

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 9.7610 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 10.4789

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 11.46

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4638

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 11.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 12.45

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 11.7308 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.4487

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 12.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.43

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 12.7157 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.4336

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 13.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.42

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 13.7006 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.4185

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 14.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.40

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 14.6855 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.4034

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 15.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.39

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 15.6704 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.3883

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 16.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 17.37

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 16.6553 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 17.3732

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 17.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 18.36

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 17.6402 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 18.3581

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 18.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 19.34

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 18.6251 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 19.3430

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 19.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 20.33

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 19.6100 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 20.3279

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 20.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 21.31

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 20.5949 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 21.3128

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 21.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 22.30

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 21.5799 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 22.2977

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 22.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 23.28

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 22.5648 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 23.2826

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 23.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 24.27

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 23.6028 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 24.2669

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 24.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 25.25

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 24.5871 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 25.2511

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 25.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 26.24

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 25.5713 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 26.2354

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 26.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 27.22

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 26.5556 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 27.2196

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 27.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 28.20

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 27.5398 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 28.2038

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 28.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 29.19

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 28.5240 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 29.1881

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 29.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 30.17

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 29.5083 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 30.1723

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 30.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 31.16

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 30.4925 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 31.1566

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 31.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 32.14

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 31.4768 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 32.1408

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 32.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 33.13

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 32.4610 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 33.1250

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 33.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 34.11

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 33.4452 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 34.1093

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 34.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.400 COST= 35.09

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.400 *****

HOURLY COSTS: ECL = 101.65 HOURS

% OF TIME UP & IN CONTROL: 98.38

NONCONFORMING ITEMS 34.4585 ALPHA = 0.003

FALSE ALARMS 0.1109 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.655 HOURS

SAMPLING 0.5040

TOTAL 35.0931

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 35.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.400 COST= 36.08

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 35.4588 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 36.0767

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 36.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.400 COST= 37.06

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 36.4424 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 37.6603

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 37.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.400 COST= 38.04

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 37.4259 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 38.0439

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 38.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.400 COST= 39.03

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 38.4095 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 39.0274

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 39.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.400 COST = 40.01

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 39.3931 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 40.0110

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 40.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.400 COST = 40.99

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 40.3767 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 40.9946

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 41.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.400 COST = 41.98

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.400 *****

HOURLY COSTS: ECL = 101.67 HOURS

% OF TIME UP & IN CONTROL: 98.36

NONCONFORMING ITEMS 41.3602 ALPHA = 0.003

FALSE ALARMS 0.0942 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.679 HOURS

SAMPLING 0.5041

TOTAL 41.9781

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 42.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.500 COST = 42.96

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.500 *****

HOURLY COSTS: ECL = 101.72 HOURS

% OF TIME UP & IN CONTROL: 98.31

NONCONFORMING ITEMS 42.3681 ALPHA = 0.003

FALSE ALARMS 0.1034 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.773 HOURS

SAMPLING 0.4704

TOTAL 42.9616

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 43.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.500 COST = 43.94

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.500 *****

HOURLY COSTS: ECL = 101.72 HOURS

% OF TIME UP & IN CONTROL: 98.31

NONCONFORMING ITEMS 43.3513 ALPHA = 0.003

FALSE ALARMS 0.1034 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.773 HOURS

SAMPLING 0.4704

TOTAL 43.9447

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 44.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.500 COST = 44.93

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.500 *****

HOURLY COSTS: ECL = 101.72 HOURS

% OF TIME UP & IN CONTROL: 98.31

NONCONFORMING ITEMS 44.3344 ALPHA = 0.003

FALSE ALARMS 0.1034 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.773 HOURS

SAMPLING 0.4704

TOTAL 44.9279

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 45.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.500 COST= 45.91

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.500 *****

HOURLY COSTS: ECL = 101.74 HOURS

% OF TIME UP & IN CONTROL: 98.29

NONCONFORMING ITEMS 45.3328 ALPHA = 0.003

FALSE ALARMS 0.0878 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.799 HOURS

SAMPLING 0.4705

TOTAL 45.9108

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 46.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.500 COST= 46.89

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.500 *****

HOURLY COSTS: ECL = 101.74 HOURS

% OF TIME UP & IN CONTROL: 98.29

NONCONFORMING ITEMS 46.3158 ALPHA = 0.003

FALSE ALARMS 0.0878 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.799 HOURS

SAMPLING 0.4705

TOTAL 46.8937

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 47.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.500 COST= 47.88

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.500 *****

HOURLY COSTS: ECL = 101.74 HOURS

% OF TIME UP & IN CONTROL: 98.29

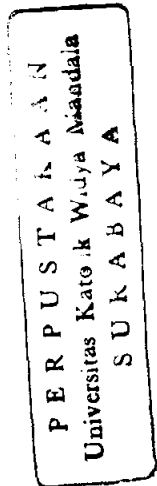
NONCONFORMING ITEMS 47.2987 ALPHA = 0.003

FALSE ALARMS 0.0878 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.799 HOURS

SAMPLING 0.4705

TOTAL 47.8766



ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 48.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.500 COST= 48.86

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.500 *****

HOURLY COSTS: ECL = 101.74 HOURS

% OF TIME UP & IN CONTROL: 98.29

NONCONFORMING ITEMS 48.2816 ALPHA = 0.003

FALSE ALARMS 0.0878 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.799 HOURS

SAMPLING 0.4705

TOTAL 48.8595

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 49.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.600 COST= 49.84

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.600 *****

HOURLY COSTS: ECL = 101.78 HOURS

% OF TIME UP & IN CONTROL: 98.25

NONCONFORMING ITEMS 49.2848 ALPHA = 0.003

FALSE ALARMS 0.0968 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 1.892 HOURS

SAMPLING 0.4410

TOTAL 49.8423

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 50.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.600 COST= 50.82

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.600 *****

HOURLY COSTS: ECL = 101.78 HOURS

% OF TIME UP & IN CONTROL: 98.25

NONCONFORMING ITEMS 50.2673 ALPHA = 0.003

FALSE ALARMS 0.0968 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 1.892 HOURS

SAMPLING 0.4410

TOTAL 50.8248

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 51.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.600 COST= 51.81

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.600 *****

HOURLY COSTS: ECL = 101.78 HOURS

% OF TIME UP & IN CONTROL: 98.25

NONCONFORMING ITEMS 51.2498 ALPHA = 0.003

FALSE ALARMS 0.0968 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 1.892 HOURS

SAMPLING 0.4410

TOTAL 51.8073

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 52.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.600 COST= 52.79

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.600 *****

HOURLY COSTS: ECL = 101.81 HOURS

% OF TIME UP & IN CONTROL: 98.22

NONCONFORMING ITEMS 52.2467 ALPHA = 0.003

FALSE ALARMS 0.0822 P = 0.834

ASSIGNABLE CAUSES 0.0196 ATS = 1.919 HOURS

SAMPLING 0.4411

TOTAL 52.7896

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 53.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.600 COST= 53.77

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.600 *****

HOURLY COSTS: ECL = 101.81 HOURS

% OF TIME UP & IN CONTROL: 98.22

NONCONFORMING ITEMS 53.2290 ALPHA = 0.003

FALSE ALARMS 0.0822 P = 0.834

ASSIGNABLE CAUSES 0.0196 ATS = 1.919 HOURS

SAMPLING 0.4411

TOTAL 53.7719

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 54.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.600 COST= 54.75

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.600 *****

HOURLY COSTS: ECL = 101.81 HOURS

% OF TIME UP & IN CONTROL: 98.22

NONCONFORMING ITEMS 54.2112 ALPHA = 0.003

FALSE ALARMS 0.0822 P = 0.834

ASSIGNABLE CAUSES 0.0196 ATS = 1.919 HOURS

SAMPLING 0.4411

TOTAL 54.7541

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 55.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.700 COST= 55.74

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.700 *****

HOURLY COSTS: ECL = 101.85 HOURS

% OF TIME UP & IN CONTROL: 98.18

NONCONFORMING ITEMS 55.2105 ALPHA = 0.003

FALSE ALARMS 0.0910 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.010 HOURS

SAMPLING 0.4151

TOTAL 55.7362

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 56.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.700 COST= 56.72

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.700 *****

HOURLY COSTS: ECL = 101.85 HOURS

% OF TIME UP & IN CONTROL: 98.18

NONCONFORMING ITEMS 56.1923 ALPHA = 0.003

FALSE ALARMS 0.0910 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.010 HOURS

SAMPLING 0.4151

TOTAL 56.7180

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 57.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.700 COST = 57.70

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.700 *****

HOURLY COSTS: ECL = 101.85 HOURS

% OF TIME UP & IN CONTROL: 98.18

NONCONFORMING ITEMS 57.1741 ALPHA = 0.003

FALSE ALARMS 0.0910 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.010 HOURS

SAMPLING 0.4151

TOTAL 57.6998

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 58.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.700 COST = 58.68

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.700 *****

HOURLY COSTS: ECL = 101.88 HOURS

% OF TIME UP & IN CONTROL: 98.16

NONCONFORMING ITEMS 58.1696 ALPHA = 0.003

FALSE ALARMS 0.0773 P = 0.834

ASSIGNABLE CAUSES 0.0196 ATS = 2.039 HOURS

SAMPLING 0.4151

TOTAL 58.6816

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 59.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.700 COST = 59.66

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.700 *****

HOURLY COSTS: ECL = 101.88 HOURS

% OF TIME UP & IN CONTROL: 98.16

NONCONFORMING ITEMS 59.1512 ALPHA = 0.003

FALSE ALARMS 0.0773 P = 0.834

ASSIGNABLE CAUSES 0.0196 ATS = 2.039 HOURS

SAMPLING 0.4151

TOTAL 59.6632

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 60.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.800 COST= 60.64

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.800 *****

HOURLY COSTS: ECL = 101.92 HOURS

% OF TIME UP & IN CONTROL: 98.12

NONCONFORMING ITEMS 60.1470 ALPHA = 0.003

FALSE ALARMS 0.0858 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.128 HOURS

SAMPLING 0.3921

TOTAL 60.6445

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 61.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.800 COST= 61.63

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.800 *****

HOURLY COSTS: ECL = 101.92 HOURS

% OF TIME UP & IN CONTROL: 98.12

NONCONFORMING ITEMS 61.1282 ALPHA = 0.003

FALSE ALARMS 0.0858 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.128 HOURS

SAMPLING 0.3921

TOTAL 61.6257

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 62.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.800 COST= 62.61

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.800 *****

HOURLY COSTS: ECL = 101.92 HOURS

% OF TIME UP & IN CONTROL: 98.12

NONCONFORMING ITEMS 62.1094 ALPHA = 0.003

FALSE ALARMS 0.0858 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.128 HOURS

SAMPLING 0.3921

TOTAL 62.6069

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 63.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.800 COST = 63.59

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.800 *****

HOURLY COSTS: ECL = 101.95 HOURS

% OF TIME UP & IN CONTROL: 98.09

NONCONFORMING ITEMS 63.1034 ALPHA = 0.003

FALSE ALARMS 0.0729 P = 0.834

ASSIGNABLE CAUSES 0.0196 ATS = 2.159 HOURS

SAMPLING 0.3921

TOTAL 63.5880

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 64.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.900 COST = 64.57

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.900 *****

HOURLY COSTS: ECL = 101.99 HOURS

% OF TIME UP & IN CONTROL: 98.05

NONCONFORMING ITEMS 64.0965 ALPHA = 0.003

FALSE ALARMS 0.0812 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.246 HOURS

SAMPLING 0.3714

TOTAL 64.5687

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 65.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.900 COST = 65.55

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.900 *****

HOURLY COSTS: ECL = 101.99 HOURS

% OF TIME UP & IN CONTROL: 98.05

NONCONFORMING ITEMS 65.0770 ALPHA = 0.003

FALSE ALARMS 0.0812 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.246 HOURS

SAMPLING 0.3714

TOTAL 65.5492

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 66.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.900 COST = 66.53

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.900 *****

HOURLY COSTS: ECL = 101.99 HOURS

% OF TIME UP & IN CONTROL: 98.05

NONCONFORMING ITEMS 66.0575 ALPHA = 0.003

FALSE ALARMS 0.0812 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.246 HOURS

SAMPLING 0.3714

TOTAL 66.5298

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 67.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.000 COST = 67.51

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.000 *****

HOURLY COSTS: ECL = 102.05 HOURS

% OF TIME UP & IN CONTROL: 97.99

NONCONFORMING ITEMS 67.0607 ALPHA = 0.003

FALSE ALARMS 0.0771 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.365 HOURS

SAMPLING 0.3529

TOTAL 67.5103

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 68.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.000 COST = 68.49

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.000 *****

HOURLY COSTS: ECL = 102.05 HOURS

% OF TIME UP & IN CONTROL: 97.99

NONCONFORMING ITEMS 68.0406 ALPHA = 0.003

FALSE ALARMS 0.0771 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.365 HOURS

SAMPLING 0.3529

TOTAL 68.4901

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 69.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.000 COST= 69.47

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.000 *****

HOURLY COSTS: ECL = 102.05 HOURS

% OF TIME UP & IN CONTROL: 97.99

NONCONFORMING ITEMS 69.0205 ALPHA = 0.003

FALSE ALARMS 0.0771 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.365 HOURS

SAMPLING 0.3529

TOTAL 69.4700

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 70.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.000 COST= 70.45

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.000 *****

HOURLY COSTS: ECL = 102.05 HOURS

% OF TIME UP & IN CONTROL: 97.99

NONCONFORMING ITEMS 70.0004 ALPHA = 0.003

FALSE ALARMS 0.0771 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.365 HOURS

SAMPLING 0.3529

TOTAL 70.4499

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 71.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.100 COST= 71.43

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.100 *****

HOURLY COSTS: ECL = 102.12 HOURS

% OF TIME UP & IN CONTROL: 97.92

NONCONFORMING ITEMS 71.0003 ALPHA = 0.003

FALSE ALARMS 0.0733 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.483 HOURS

SAMPLING 0.3361

TOTAL 71.4292

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 72.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.100 COST = 72.41

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.100 *****

HOURLY COSTS: ECL = 102.12 HOURS

% OF TIME UP & IN CONTROL: 97.92

NONCONFORMING ITEMS 71.9795 ALPHA = 0.003

FALSE ALARMS 0.0733 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.483 HOURS

SAMPLING 0.3361

TOTAL 72.4084

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 73.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.200 COST = 73.39

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.200 *****

HOURLY COSTS: ECL = 102.19 HOURS

% OF TIME UP & IN CONTROL: 97.86

NONCONFORMING ITEMS 72.9773 ALPHA = 0.003

FALSE ALARMS 0.0699 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.601 HOURS

SAMPLING 0.3208

TOTAL 73.3876

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 74.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.200 COST = 74.37

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.200 *****

HOURLY COSTS: ECL = 102.19 HOURS

% OF TIME UP & IN CONTROL: 97.86

NONCONFORMING ITEMS 73.9559 ALPHA = 0.003

FALSE ALARMS 0.0699 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.601 HOURS

SAMPLING 0.3208

TOTAL 74.3662

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 75.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L=2.95 H= 2.200 COST= 75.34

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.200 *****

HOURLY COSTS: ECL = 102.19 HOURS

% OF TIME UP & IN CONTROL: 97.86

NONCONFORMING ITEMS 74.9345 ALPHA = 0.003

FALSE ALARMS 0.0699 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.601 HOURS

SAMPLING 0.3208

TOTAL 75.3448

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 76.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L=2.95 H= 2.300 COST= 76.32

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.300 *****

HOURLY COSTS: ECL = 102.26 HOURS

% OF TIME UP & IN CONTROL: 97.79

NONCONFORMING ITEMS 75.9297 ALPHA = 0.003

FALSE ALARMS 0.0668 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.719 HOURS

SAMPLING 0.3068

TOTAL 76.3229

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 77.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L=2.95 H= 2.300 COST= 77.30

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.300 *****

HOURLY COSTS: ECL = 102.26 HOURS

% OF TIME UP & IN CONTROL: 97.79

NONCONFORMING ITEMS 76.9076 ALPHA = 0.003

FALSE ALARMS 0.0668 P = 0.846

ASSIGNABLE CAUSES 0.0196 ATS = 2.719 HOURS

SAMPLING 0.3068

TOTAL 77.3008

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 78.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.400 COST= 78.28

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.400 *****

HOURLY COSTS: ECL = 102.33 HOURS

% OF TIME UP & IN CONTROL: 97.73

NONCONFORMING ITEMS 77.9008 ALPHA = 0.003

FALSE ALARMS 0.0639 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 2.838 HOURS

SAMPLING 0.2941

TOTAL 78.2783

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 79.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.400 COST= 79.26

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.400 *****

HOURLY COSTS: ECL = 102.33 HOURS

% OF TIME UP & IN CONTROL: 97.73

NONCONFORMING ITEMS 78.8781 ALPHA = 0.003

FALSE ALARMS 0.0639 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 2.838 HOURS

SAMPLING 0.2941

TOTAL 79.2556

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 80.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.500 COST= 80.23

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.500 *****

HOURLY COSTS: ECL = 102.39 HOURS

% OF TIME UP & IN CONTROL: 97.66

NONCONFORMING ITEMS 79.8693 ALPHA = 0.003

FALSE ALARMS 0.0613 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 2.956 HOURS

SAMPLING 0.2823

TOTAL 80.2324

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 81.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.600 COST = 81.21

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.600 *****

HOURLY COSTS: ECL = 102.46 HOURS

% OF TIME UP & IN CONTROL: 97.60

NONCONFORMING ITEMS 80.8591 ALPHA = 0.003

FALSE ALARMS 0.0589 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.074 HOURS

SAMPLING 0.2714

TOTAL 81.2090

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 82.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.600 COST = 82.18

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.600 *****

HOURLY COSTS: ECL = 102.46 HOURS

% OF TIME UP & IN CONTROL: 97.60

NONCONFORMING ITEMS 81.8351 ALPHA = 0.003

FALSE ALARMS 0.0549 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.074 HOURS

SAMPLING 0.2714

TOTAL 82.1849

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 83.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 2.700 COST = 83.16

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 2.700 *****

HOURLY COSTS: ECL = 102.53 HOURS

% OF TIME UP & IN CONTROL: 97.53

NONCONFORMING ITEMS 82.8230 ALPHA = 0.003

FALSE ALARMS 0.0566 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.192 HOURS

SAMPLING 0.2614

TOTAL 83.1605

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 84.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.800 COST= 84.14

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.800 *****

HOURLY COSTS: ECL = 102.60 HOURS

% OF TIME UP & IN CONTROL: 97.47

NONCONFORMING ITEMS 83.8095 ALPHA = 0.003

FALSE ALARMS 0.0545 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.310 HOURS

SAMPLING 0.2521

TOTAL 84.1356

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 85.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 2.900 COST= 85.11

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 2.900 *****

HOURLY COSTS: ECL = 102.67 HOURS

% OF TIME UP & IN CONTROL: 97.40

NONCONFORMING ITEMS 84.7946 ALPHA = 0.003

FALSE ALARMS 0.0526 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.429 HOURS

SAMPLING 0.2434

TOTAL 85.1101

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 86.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 3.000 COST= 86.08

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 3.000 *****

HOURLY COSTS: ECL = 102.73 HOURS

% OF TIME UP & IN CONTROL: 97.34

NONCONFORMING ITEMS 85.7785 ALPHA = 0.003

FALSE ALARMS 0.0508 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.547 HOURS

SAMPLING 0.2353

TOTAL 86.0840

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 87.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 3.100 COST= 87.06

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 3.100 *****

HOURLY COSTS: ECL = 102.80 HOURS

% OF TIME UP & IN CONTROL: 97.27

NONCONFORMING ITEMS 86.7610 ALPHA = 0.003

FALSE ALARMS 0.0491 P = 0.846

ASSIGNABLE CAUSES 0.0195 ATS = 3.665 HOURS

SAMPLING 0.2277

TOTAL 87.0572

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 88.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 3.200 COST= 88.03

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 3.200 *****

HOURLY COSTS: ECL = 102.87 HOURS

% OF TIME UP & IN CONTROL: 97.21

NONCONFORMING ITEMS 87.7422 ALPHA = 0.003

FALSE ALARMS 0.0475 P = 0.846

ASSIGNABLE CAUSES 0.0194 ATS = 3.783 HOURS

SAMPLING 0.2206

TOTAL 88.0297

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 89.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 3.300 COST= 89.00

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 3.300 *****

HOURLY COSTS: ECL = 102.94 HOURS

% OF TIME UP & IN CONTROL: 97.14

NONCONFORMING ITEMS 88.7221 ALPHA = 0.003

FALSE ALARMS 0.0460 P = 0.846

ASSIGNABLE CAUSES 0.0194 ATS = 3.902 HOURS

SAMPLING 0.2139

TOTAL 89.0014

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 90.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 3.500 COST = 89.97

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 3.500 *****

HOURLY COSTS: ECL = 103.08 HOURS

% OF TIME UP & IN CONTROL: 97.01

NONCONFORMING ITEMS 89.7078 ALPHA = 0.003

FALSE ALARMS 0.0433 P = 0.846

ASSIGNABLE CAUSES 0.0194 ATS = 4.138 HOURS

SAMPLING 0.2017

TOTAL 89.9721

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 91.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 3.700 COST = 90.94

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 3.700 *****

HOURLY COSTS: ECL = 103.21 HOURS

% OF TIME UP & IN CONTROL: 96.89

NONCONFORMING ITEMS 90.6908 ALPHA = 0.003

FALSE ALARMS 0.0408 P = 0.846

ASSIGNABLE CAUSES 0.0194 ATS = 4.375 HOURS

SAMPLING 0.1908

TOTAL 90.9418

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 92.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 3.900 COST = 91.91

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 3.900 *****

HOURLY COSTS: ECL = 103.35 HOURS

% OF TIME UP & IN CONTROL: 96.76

NONCONFORMING ITEMS 91.6712 ALPHA = 0.003

FALSE ALARMS 0.0387 P = 0.846

ASSIGNABLE CAUSES 0.0194 ATS = 4.611 HOURS

SAMPLING 0.1810

TOTAL 91.9101

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 93.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 4.100 COST= 92.88

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 4.100 *****

HOURLY COSTS: ECL = 103.49 HOURS

% OF TIME UP & IN CONTROL: 96.63

NONCONFORMING ITEMS 92.6489 ALPHA = 0.003

FALSE ALARMS 0.0367 P = 0.846

ASSIGNABLE CAUSES 0.0193 ATS = 4.847 HOURS

SAMPLING 0.1722

TOTAL 92.8771

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 94.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 4.400 COST= 93.84

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 4.400 *****

HOURLY COSTS: ECL = 103.70 HOURS

% OF TIME UP & IN CONTROL: 96.44

NONCONFORMING ITEMS 93.6284 ALPHA = 0.003

FALSE ALARMS 0.0341 P = 0.846

ASSIGNABLE CAUSES 0.0193 ATS = 5.202 HOURS

SAMPLING 0.1604

TOTAL 93.8422

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 95.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 4.800 COST= 94.81

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 4.800 *****

HOURLY COSTS: ECL = 103.97 HOURS

% OF TIME UP & IN CONTROL: 96.18

NONCONFORMING ITEMS 94.6077 ALPHA = 0.003

FALSE ALARMS 0.0311 P = 0.846

ASSIGNABLE CAUSES 0.0192 ATS = 5.675 HOURS

SAMPLING 0.1471

TOTAL 94.8050

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 96.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 5.400 COST= 95.77

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 5.400 *****

HOURLY COSTS: ECL = 104.38 HOURS

% OF TIME UP & IN CONTROL: 95.80

NONCONFORMING ITEMS 95.5877 ALPHA = 0.003

FALSE ALARMS 0.0274 P = 0.846

ASSIGNABLE CAUSES 0.0192 ATS = 6.384 HOURS

SAMPLING 0.1307

TOTAL 95.7650

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 97.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 6.100 COST= 96.72

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 6.100 *****

HOURLY COSTS: ECL = 104.87 HOURS

% OF TIME UP & IN CONTROL: 95.36

NONCONFORMING ITEMS 96.5623 ALPHA = 0.003

FALSE ALARMS 0.0241 P = 0.846

ASSIGNABLE CAUSES 0.0191 ATS = 7.212 HOURS

SAMPLING 0.1157

TOTAL 96.7212

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 98.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 7.200 COST= 97.67

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 7.200 *****

HOURLY COSTS: ECL = 105.63 HOURS

% OF TIME UP & IN CONTROL: 94.67

NONCONFORMING ITEMS 97.5346 ALPHA = 0.003

FALSE ALARMS 0.0201 P = 0.846

ASSIGNABLE CAUSES 0.0189 ATS = 8.513 HOURS

SAMPLING 0.0980

TOTAL 97.6717

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 99.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 9.000 COST= 98.61

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 9.000 *****

HOURLY COSTS: ECL = 106.88 HOURS

% OF TIME UP & IN CONTROL: 93.56

NONCONFORMING ITEMS 98.4999 ALPHA = 0.003

FALSE ALARMS 0.0158 P = 0.846

ASSIGNABLE CAUSES 0.0187 ATS = 10.641 HOURS

SAMPLING 0.0784

TOTAL 98.6128

3.4 Perubahan C₁

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4638

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 105.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.100 COST= 11.51

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 10.7254 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 11.5069

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 110.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 11.55

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 10.7669 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 11.5483

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 115.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 11.59

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 10.8083 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 11.5898

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 120.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.100 COST = 11.63

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.100 *****

HOURLY COSTS: ECL = 101.46 HOURS

% OF TIME UP & IN CONTROL: 98.56

NONCONFORMING ITEMS 10.8497 ALPHA = 0.003

FALSE ALARMS 0.1203 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.320 HOURS

SAMPLING 0.6415

TOTAL 11.6312

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 125.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.000 COST = 11.67

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.000 *****

HOURLY COSTS: ECL = 101.40 HOURS

% OF TIME UP & IN CONTROL: 98.62

NONCONFORMING ITEMS 10.8119 ALPHA = 0.003

FALSE ALARMS 0.1325 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.200 HOURS

SAMPLING 0.7056

TOTAL 11.6697

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 130.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.000 COST = 11.71

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.000 *****

HOURLY COSTS: ECL = 101.40 HOURS

% OF TIME UP & IN CONTROL: 98.62

NONCONFORMING ITEMS 10.8499 ALPHA = 0.003

FALSE ALARMS 0.1325 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.200 HOURS

SAMPLING 0.7056

TOTAL 11.7077

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 135.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.000 COST = 11.75

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.000 *****

HOURLY COSTS: ECL = 101.40 HOURS

% OF TIME UP & IN CONTROL: 98.62

NONCONFORMING ITEMS 10.8879 ALPHA = 0.003

FALSE ALARMS 0.1325 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.200 HOURS

SAMPLING 0.7056

TOTAL 11.7457

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 140.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.000 COST = 11.78

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.000 *****

HOURLY COSTS: ECL = 101.40 HOURS

% OF TIME UP & IN CONTROL: 98.62

NONCONFORMING ITEMS 10.9259 ALPHA = 0.003

FALSE ALARMS 0.1325 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.200 HOURS

SAMPLING 0.7056

TOTAL 11.7837

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 145.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.000 COST = 11.82

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.000 *****

HOURLY COSTS: ECL = 101.40 HOURS

% OF TIME UP & IN CONTROL: 98.62

NONCONFORMING ITEMS 10.9639 ALPHA = 0.003

FALSE ALARMS 0.1325 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.200 HOURS

SAMPLING 0.7056

TOTAL 11.8217

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 15.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.05 H = 5.500 COST = 10.30

***** SUMMARY INFO FOR PLAN N = 8 L = 3.05 H = 5.500 *****

HOURLY COSTS: ECL = 104.18 HOURS

% OF TIME UP & IN CONTROL: 95.98

NONCONFORMING ITEMS 10.1139 ALPHA = 0.002

FALSE ALARMS 0.0194 P = 0.883

ASSIGNABLE CAUSES 0.0192 ATS = 6.225 HOURS

SAMPLING 0.1464

TOTAL 10.2989

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 150.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 0.900 COST = 11.86

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 0.900 *****

HOURLY COSTS: ECL = 101.33 HOURS

% OF TIME UP & IN CONTROL: 98.69

NONCONFORMING ITEMS 10.9054 ALPHA = 0.003

FALSE ALARMS 0.1474 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.080 HOURS

SAMPLING 0.7840

TOTAL 11.8565

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 155.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 0.900 COST = 11.89

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 0.900 *****

HOURLY COSTS: ECL = 101.33 HOURS

% OF TIME UP & IN CONTROL: 98.69

NONCONFORMING ITEMS 10.9399 ALPHA = 0.003

FALSE ALARMS 0.1474 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.080 HOURS

SAMPLING 0.7840

TOTAL 11.8910

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 160.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 0.900 COST = 11.93

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 0.900 *****

HOURLY COSTS: ECL = 101.33 HOURS

% OF TIME UP & IN CONTROL: 98.69

NONCONFORMING ITEMS 10.9745 ALPHA = 0.003

FALSE ALARMS 0.1474 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.080 HOURS

SAMPLING 0.7840

TOTAL 11.9256

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 165.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.900 COST= 11.96

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.900 *****

HOURLY COSTS: ECL = 101.33 HOURS

% OF TIME UP & IN CONTROL: 98.69

NONCONFORMING ITEMS 11.0090 ALPHA = 0.003

FALSE ALARMS 0.1474 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.080 HOURS

SAMPLING 0.7840

TOTAL 11.9601

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 170.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.900 COST= 11.99

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.900 *****

HOURLY COSTS: ECL = 101.33 HOURS

% OF TIME UP & IN CONTROL: 98.69

NONCONFORMING ITEMS 11.0436 ALPHA = 0.003

FALSE ALARMS 0.1474 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.080 HOURS

SAMPLING 0.7840

TOTAL 11.9947

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 175.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.900 COST= 12.03

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.900 *****

HOURLY COSTS: ECL = 101.33 HOURS

% OF TIME UP & IN CONTROL: 98.69

NONCONFORMING ITEMS 11.0781 ALPHA = 0.003

FALSE ALARMS 0.1474 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.080 HOURS

SAMPLING 0.7840

TOTAL 12.0292

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 180.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.06

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 10.9954 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.0630

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 185.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.09

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.0265 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.0942

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 190.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.13

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.0576 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.1253

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 195.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.16

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.0887 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.1564

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 20.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 3.900 COST= 10.44

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 3.900 *****

HOURLY COSTS: ECL = 103.16 HOURS

% OF TIME UP & IN CONTROL: 96.93

NONCONFORMING ITEMS 10.1891 ALPHA = 0.002

FALSE ALARMS 0.0279 P = 0.883

ASSIGNABLE CAUSES 0.0194 ATS = 4.414 HOURS

SAMPLING 0.2065

TOTAL 10.4429

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 200.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.19

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.1198 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.1875

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 205.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.22

***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.1510 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.2186

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 210.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.25

***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.1821 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.2497

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 215.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.28

***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 0.800 *****

HOURLY COSTS: ECL = 101.26 HOURS

% OF TIME UP & IN CONTROL: 98.75

NONCONFORMING ITEMS 11.2132 ALPHA = 0.003

FALSE ALARMS 0.1660 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS

SAMPLING 0.8819

TOTAL 12.2809

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 220.00 Y = 50.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.800 COST= 12.31
***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 0.800 *****
HOURLY COSTS: ECL = 101.26 HOURS
% OF TIME UP & IN CONTROL: 98.75
NONCONFORMING ITEMS 11.2443 ALPHA = 0.003
FALSE ALARMS 0.1660 P = 0.834
ASSIGNABLE CAUSES 0.0198 ATS = 0.960 HOURS
SAMPLING 0.8819
TOTAL 12.3120

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 225.00 Y = 50.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 7 L= 2.95 H= 0.800 COST= 12.34
***** SUMMARY INFO FOR PLAN N= 7 L = 2.95 H = 0.800 *****
HOURLY COSTS: ECL = 101.26 HOURS
% OF TIME UP & IN CONTROL: 98.76
NONCONFORMING ITEMS 11.2456 ALPHA = 0.003
FALSE ALARMS 0.1954 P = 0.846
ASSIGNABLE CAUSES 0.0198 ATS = 0.946 HOURS
SAMPLING 0.8819
TOTAL 12.3426

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 230.00 Y = 50.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.37
***** SUMMARY INFO FOR PLAN N= 7 L = 3.00 H = 0.700 *****
HOURLY COSTS: ECL = 101.20 HOURS
% OF TIME UP & IN CONTROL: 98.82
NONCONFORMING ITEMS 11.1546 ALPHA = 0.003
FALSE ALARMS 0.1899 P = 0.834
ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS
SAMPLING 1.0079
TOTAL 12.3721

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 235.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.40

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.1822 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.5998

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 240.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.43

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.2099 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.4274

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 245.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.2376 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.4551

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 25.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 3.200 COST= 10.55

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 3.200 *****

HOURLY COSTS: ECL = 102.72 HOURS

% OF TIME UP & IN CONTROL: 97.35

NONCONFORMING ITEMS 10.2491 ALPHA = 0.002

FALSE ALARMS 0.0343 P = 0.883

ASSIGNABLE CAUSES 0.0195 ATS = 3.622 HOURS

SAMPLING 0.2516

TOTAL 10.5545

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 250.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.48

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.2652 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.4828

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 255.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.51

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.2929 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.5105

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 260.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.54

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.3206 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.5381

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 270.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.59

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.3759 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.5935

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 275.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.62

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.4036 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.6212

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 280.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.65

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.4313 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.6488

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 285.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.700 COST= 12.68

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.700 *****

HOURLY COSTS: ECL = 101.20 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.4590 ALPHA = 0.003

FALSE ALARMS 0.1899 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.840 HOURS

SAMPLING 1.0079

TOTAL 12.6765

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 290.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 0.700 COST= 12.70

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 0.700 *****

HOURLY COSTS: ECL = 101.19 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.4526 ALPHA = 0.003

FALSE ALARMS 0.2235 P = 0.846

ASSIGNABLE CAUSES 0.0198 ATS = 0.828 HOURS

SAMPLING 1.0078

TOTAL 12.7037

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 295.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 0.700 COST= 12.73

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 0.700 *****

HOURLY COSTS: ECL = 101.19 HOURS

% OF TIME UP & IN CONTROL: 98.82

NONCONFORMING ITEMS 11.4797 ALPHA = 0.003

FALSE ALARMS 0.2235 P = 0.846

ASSIGNABLE CAUSES 0.0198 ATS = 0.828 HOURS

SAMPLING 1.0078

TOTAL 12.7308

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 30.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 2.700 COST= 10.65

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 2.700 *****

HOURLY COSTS: ECL = 102.40 HOURS

% OF TIME UP & IN CONTROL: 97.66

NONCONFORMING ITEMS 10.2906 ALPHA = 0.002

FALSE ALARMS 0.0408 P = 0.883

ASSIGNABLE CAUSES 0.0195 ATS = 3.056 HOURS

SAMPLING 0.2982

TOTAL 10.6492

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 300.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.05 H= 0.600 COST= 12.76

***** SUMMARY INFO FOR PLAN N= 7 L= 3.05 H= 0.600 *****

HOURLY COSTS: ECL = 101.14 HOURS

% OF TIME UP & IN CONTROL: 98.87

NONCONFORMING ITEMS 11.3742 ALPHA = 0.002

FALSE ALARMS 0.1880 P = 0.821

ASSIGNABLE CAUSES 0.0198 ATS = 0.731 HOURS

SAMPLING 1.1759

TOTAL 12.7578

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 305.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.05 H= 0.600 COST= 12.78

***** SUMMARY INFO FOR PLAN N= 7 L= 3.05 H= 0.600 *****

HOURLY COSTS: ECL = 101.14 HOURS

% OF TIME UP & IN CONTROL: 98.87

NONCONFORMING ITEMS 11.3989 ALPHA = 0.002

FALSE ALARMS 0.1880 P = 0.821

ASSIGNABLE CAUSES 0.0198 ATS = 0.731 HOURS

SAMPLING 1.1759

TOTAL 12.7826

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 310.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.600 COST= 12.81

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.600 *****

HOURLY COSTS: ECL = 101.13 HOURS

% OF TIME UP & IN CONTROL: 98.88

NONCONFORMING ITEMS 11.3899 ALPHA = 0.003

FALSE ALARMS 0.2218 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.720 HOURS

SAMPLING 1.1758

TOTAL 12.8072

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 315.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 0.600 COST= 12.83

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 0.600 *****

HOURLY COSTS: ECL = 101.13 HOURS

% OF TIME UP & IN CONTROL: 98.88

NONCONFORMING ITEMS 11.4141 ALPHA = 0.003

FALSE ALARMS 0.2218 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.720 HOURS

SAMPLING 1.1758

TOTAL 12.8315

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 320.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 0.600 COST = 12.86

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 0.600 *****

HOURLY COSTS: ECL = 101.13 HOURS

% OF TIME UP & IN CONTROL: 98.88

NONCONFORMING ITEMS 11.4383 ALPHA = 0.003

FALSE ALARMS 0.2218 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.720 HOURS

SAMPLING 1.1758

TOTAL 12.8557

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 325.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 0.600 COST = 12.88

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 0.600 *****

HOURLY COSTS: ECL = 101.13 HOURS

% OF TIME UP & IN CONTROL: 98.88

NONCONFORMING ITEMS 11.4625 ALPHA = 0.003

FALSE ALARMS 0.2218 P = 0.834

ASSIGNABLE CAUSES 0.0198 ATS = 0.720 HOURS

SAMPLING 1.1758

TOTAL 12.8799

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 35.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.05 H = 2.400 COST = 10.73

***** SUMMARY INFO FOR PLAN N = 8 L = 3.05 H = 2.400 *****

HOURLY COSTS: ECL = 102.21 HOURS

% OF TIME UP & IN CONTROL: 97.84

NONCONFORMING ITEMS 10.3320 ALPHA = 0.002

FALSE ALARMS 0.0461 P = 0.883

ASSIGNABLE CAUSES 0.0196 ATS = 2.716 HOURS

SAMPLING 0.3355

TOTAL 10.7332

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 40.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 2.200 COST= 10.81

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 2.200 *****

HOURLY COSTS: ECL = 102.08 HOURS

% OF TIME UP & IN CONTROL: 97.96

NONCONFORMING ITEMS 10.3734 ALPHA = 0.002

FALSE ALARMS 0.0504 P = 0.883

ASSIGNABLE CAUSES 0.0196 ATS = 2.490 HOURS

SAMPLING 0.3660

TOTAL 10.8094

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 45.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 2.100 COST= 10.88

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 2.100 *****

HOURLY COSTS: ECL = 102.02 HOURS

% OF TIME UP & IN CONTROL: 98.02

NONCONFORMING ITEMS 10.4241 ALPHA = 0.002

FALSE ALARMS 0.0529 P = 0.883

ASSIGNABLE CAUSES 0.0196 ATS = 2.377 HOURS

SAMPLING 0.3834

TOTAL 10.8799

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 50.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.900 COST= 10.95

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.900 *****

HOURLY COSTS: ECL = 101.90 HOURS

% OF TIME UP & IN CONTROL: 98.14

NONCONFORMING ITEMS 10.4438 ALPHA = 0.002

FALSE ALARMS 0.0585 P = 0.883

ASSIGNABLE CAUSES 0.0196 ATS = 2.151 HOURS

SAMPLING 0.4238

TOTAL 10.9457

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 55.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.05 H = 1.800 COST = 11.01

***** SUMMARY INFO FOR PLAN N = 8 L = 3.05 H = 1.800 *****

HOURLY COSTS: ECL = 101.83 HOURS

% OF TIME UP & IN CONTROL: 98.20

NONCONFORMING ITEMS 10.4790 ALPHA = 0.002

FALSE ALARMS 0.0619 P = 0.883

ASSIGNABLE CAUSES 0.0196 ATS = 2.037 HOURS

SAMPLING 0.4473

TOTAL 11.0078

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 60.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.05 H = 1.700 COST = 11.07

***** SUMMARY INFO FOR PLAN N = 8 L = 3.05 H = 1.700 *****

HOURLY COSTS: ECL = 101.77 HOURS

% OF TIME UP & IN CONTROL: 98.26

NONCONFORMING ITEMS 10.5080 ALPHA = 0.002

FALSE ALARMS 0.0656 P = 0.883

ASSIGNABLE CAUSES 0.0197 ATS = 1.924 HOURS

SAMPLING 0.4736

TOTAL 11.0668

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 65.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.500 COST = 11.12

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.500 *****

HOURLY COSTS: ECL = 101.74 HOURS

% OF TIME UP & IN CONTROL: 98.29

NONCONFORMING ITEMS 10.5454 ALPHA = 0.003

FALSE ALARMS 0.0878 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.799 HOURS

SAMPLING 0.4705

TOTAL 11.1233

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 70.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.600 COST= 11.18

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.600 *****

HOURLY COSTS: ECL = 101.71 HOURS

% OF TIME UP & IN CONTROL: 98.32

NONCONFORMING ITEMS 10.5845 ALPHA = 0.002

FALSE ALARMS 0.0698 P = 0.883

ASSIGNABLE CAUSES 0.0197 ATS = 1.811 HOURS

SAMPLING 0.5032

TOTAL 11.1771

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 75.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.500 COST= 11.23

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.500 *****

HOURLY COSTS: ECL = 101.64 HOURS

% OF TIME UP & IN CONTROL: 98.38

NONCONFORMING ITEMS 10.5979 ALPHA = 0.002

FALSE ALARMS 0.0745 P = 0.883

ASSIGNABLE CAUSES 0.0197 ATS = 1.698 HOURS

SAMPLING 0.5367

TOTAL 11.2288

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 80.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 11.28

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 10.6147 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 11.2787

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 85.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.300 COST= 11.33

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.300 *****

HOURLY COSTS: ECL = 101.60 HOURS

% OF TIME UP & IN CONTROL: 98.42

NONCONFORMING ITEMS 10.6630 ALPHA = 0.003

FALSE ALARMS 0.1015 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.559 HOURS

SAMPLING 0.5428

TOTAL 11.3270

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 90.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.37

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.6562 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.3741

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 95.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.42

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7011 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4190

3.5 Perubahan Y

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 0.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 1 L = 1.60 H = 0.100 COST = 10.11

***** SUMMARY INFO FOR PLAN N = 1 L = 1.60 H = 0.100 *****

HOURLY COSTS: ECL = 111.73 HOURS

% OF TIME UP & IN CONTROL: 89.50

NONCONFORMING ITEMS 9.1083 ALPHA = 0.110

FALSE ALARMS 0.0000 P = 0.461

ASSIGNABLE CAUSES 0.0179 ATS = 0.217 HOURS

SAMPLING 0.9862

TOTAL 10.1125

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 10.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 5 L = 2.45 H = 1.000 COST = 11.28

***** SUMMARY INFO FOR PLAN N = 5 L = 2.45 H = 1.000 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.6138 ALPHA = 0.014

FALSE ALARMS 0.1400 P = 0.817

ASSIGNABLE CAUSES 0.0197 ATS = 1.224 HOURS

SAMPLING 0.5063

TOTAL 11.2798

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 11.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 5 L = 2.45 H = 1.000 COST = 11.29

***** SUMMARY INFO FOR PLAN N = 5 L = 2.45 H = 1.000 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.6138 ALPHA = 0.014

FALSE ALARMS 0.1540 P = 0.817

ASSIGNABLE CAUSES 0.0197 ATS = 1.224 HOURS

SAMPLING 0.5063

TOTAL 11.2938

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 12.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.55 H= 1.100 COST= 11.31

***** SUMMARY INFO FOR PLAN N= 6 L= 2.55 H= 1.100 *****

HOURLY COSTS: ECL = 101.47 HOURS

% OF TIME UP & IN CONTROL: 98.55

NONCONFORMING ITEMS 10.6196 ALPHA = 0.011

FALSE ALARMS 0.1152 P = 0.870

ASSIGNABLE CAUSES 0.0197 ATS = 1.265 HOURS

SAMPLING 0.5507

TOTAL 11.3052

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 13.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.60 H= 1.100 COST= 11.31

***** SUMMARY INFO FOR PLAN N= 6 L= 2.60 H= 1.100 *****

HOURLY COSTS: ECL = 101.48 HOURS

% OF TIME UP & IN CONTROL: 98.55

NONCONFORMING ITEMS 10.6351 ALPHA = 0.009

FALSE ALARMS 0.1080 P = 0.859

ASSIGNABLE CAUSES 0.0197 ATS = 1.281 HOURS

SAMPLING 0.5508

TOTAL 11.3136

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 14.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.60 H= 1.100 COST= 11.32

***** SUMMARY INFO FOR PLAN N= 6 L= 2.60 H= 1.100 *****

HOURLY COSTS: ECL = 101.48 HOURS

% OF TIME UP & IN CONTROL: 98.55

NONCONFORMING ITEMS 10.6351 ALPHA = 0.009

FALSE ALARMS 0.1163 P = 0.859

ASSIGNABLE CAUSES 0.0197 ATS = 1.281 HOURS

SAMPLING 0.5508

TOTAL 11.3219

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 15.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.65 H= 1.100 COST= 11.33

***** SUMMARY INFO FOR PLAN N= 6 L= 2.65 H= 1.100 *****

HOURLY COSTS: ECL = 101.48 HOURS

% OF TIME UP & IN CONTROL: 98.54

NONCONFORMING ITEMS 10.6516 ALPHA = 0.008

FALSE ALARMS 0.1076 P = 0.847

ASSIGNABLE CAUSES 0.0197 ATS = 1.298 HOURS

SAMPLING 0.5509

TOTAL 11.3298

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 16.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.65 H= 1.100 COST= 11.34

***** SUMMARY INFO FOR PLAN N= 6 L= 2.65 H= 1.100 *****

HOURLY COSTS: ECL = 101.48 HOURS

% OF TIME UP & IN CONTROL: 98.54

NONCONFORMING ITEMS 10.6516 ALPHA = 0.008

FALSE ALARMS 0.1147 P = 0.847

ASSIGNABLE CAUSES 0.0197 ATS = 1.298 HOURS

SAMPLING 0.5509

TOTAL 11.3369

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 17.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.65 H= 1.100 COST= 11.34

***** SUMMARY INFO FOR PLAN N= 6 L= 2.65 H= 1.100 *****

HOURLY COSTS: ECL = 101.48 HOURS

% OF TIME UP & IN CONTROL: 98.54

NONCONFORMING ITEMS 10.6516 ALPHA = 0.008

FALSE ALARMS 0.1219 P = 0.847

ASSIGNABLE CAUSES 0.0197 ATS = 1.298 HOURS

SAMPLING 0.5509

TOTAL 11.3441

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 18.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.70 H= 1.100 COST= 11.35

***** SUMMARY INFO FOR PLAN N= 6 L= 2.70 H= 1.100 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6692 ALPHA = 0.007

FALSE ALARMS 0.1112 P = 0.835

ASSIGNABLE CAUSES 0.0197 ATS = 1.317 HOURS

SAMPLING 0.5509

TOTAL 11.3511

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 19.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.70 H= 1.100 COST= 11.36

***** SUMMARY INFO FOR PLAN N= 6 L= 2.70 H= 1.100 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6692 ALPHA = 0.007

FALSE ALARMS 0.1174 P = 0.835

ASSIGNABLE CAUSES 0.0197 ATS = 1.317 HOURS

SAMPLING 0.5509

TOTAL 11.3572

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 20.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.70 H= 1.100 COST= 11.36

***** SUMMARY INFO FOR PLAN N= 6 L= 2.70 H= 1.100 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6692 ALPHA = 0.007

FALSE ALARMS 0.1235 P = 0.835

ASSIGNABLE CAUSES 0.0197 ATS = 1.317 HOURS

SAMPLING 0.5509

TOTAL 11.3634

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 21.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.70 H= 1.100 COST= 11.37

***** SUMMARY INFO FOR PLAN N= 6 L= 2.70 H= 1.100 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6692 ALPHA = 0.007

FALSE ALARMS 0.1297 P = 0.835

ASSIGNABLE CAUSES 0.0197 ATS = 1.317 HOURS

SAMPLING 0.5509

TOTAL 11.3696

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 22.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.75 H= 1.100 COST= 11.38

***** SUMMARY INFO FOR PLAN N= 6 L= 2.75 H= 1.100 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.6881 ALPHA = 0.006

FALSE ALARMS 0.1168 P = 0.822

ASSIGNABLE CAUSES 0.0197 ATS = 1.338 HOURS

SAMPLING 0.5510

TOTAL 11.3756

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 23.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.75 H= 1.100 COST= 11.38

***** SUMMARY INFO FOR PLAN N= 6 L= 2.75 H= 1.100 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.6881 ALPHA = 0.006

FALSE ALARMS 0.1221 P = 0.822

ASSIGNABLE CAUSES 0.0197 ATS = 1.338 HOURS

SAMPLING 0.5510

TOTAL 11.3809

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 24.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 6 L= 2.75 H= 1.100 COST= 11.39

***** SUMMARY INFO FOR PLAN N= 6 L= 2.75 H= 1.100 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.6881 ALPHA = 0.006

FALSE ALARMS .1274 P = 0.822

ASSIGNABLE CAUSES .0197 ATS = 1.338 HOURS

SAMPLING .5510

TOTAL 1.3852

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 25.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.85 H= 1.200 COST= 11.39

***** SUMMARY INFO FOR PLAN N= 7 L= 2.85 H= 1.200 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6939 ALPHA = 0.004

FALSE ALARMS 0.0892 P = 0.868

ASSIGNABLE CAUSES 0.0197 ATS = 1.382 HOURS

SAMPLING 0.5880

TOTAL 1.3907

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 26.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.85 H= 1.200 COST= 11.39

***** SUMMARY INFO FOR PLAN N= 7 L= 2.85 H= 1.200 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6939 ALPHA = 0.004

FALSE ALARMS .0928 P = 0.868

ASSIGNABLE CAUSES .0197 ATS = 1.382 HOURS

SAMPLING .5880

TOTAL 1.3943

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 27.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.85 H= 1.200 COST= 11.40

***** SUMMARY INFO FOR PLAN N= 7 L= 2.85 H= 1.200 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6939 ALPHA = 0.004

FALSE ALARMS .0963 P = 0.868

ASSIGNABLE CAUSES .0197 ATS = 1.382 HOURS

SAMPLING .5880

TOTAL 1.3979

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 28.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.85 H= 1.200 COST= 11.40

***** SUMMARY INFO FOR PLAN N= 7 L= 2.85 H= 1.200 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6939 ALPHA = 0.004

FALSE ALARMS .0999 P = 0.868

ASSIGNABLE CAUSES .0197 ATS = 1.382 HOURS

SAMPLING .5880

TOTAL 1.4014

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 29.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.85 H= 1.200 COST= 11.41

***** SUMMARY INFO FOR PLAN N= 7 L= 2.85 H= 1.200 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6939 ALPHA = 0.004

FALSE ALARMS .1035 P = 0.868

ASSIGNABLE CAUSES .0197 ATS = 1.382 HOURS

SAMPLING .5880

TOTAL 1.4050

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 30.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.85 H= 1.200 COST= 11.41

***** SUMMARY INFO FOR PLAN N= 7 L= 2.85 H= 1.200 *****

HOURLY COSTS: ECL = 101.49 HOURS

% OF TIME UP & IN CONTROL: 98.53

NONCONFORMING ITEMS 10.6939 ALPHA = 0.004

FALSE ALARMS .1071 P = 0.868

ASSIGNABLE CAUSES .0197 ATS = 1.382 HOURS

SAMPLING .5880

TOTAL 1.4086

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 31.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.41

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .0944 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4121

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 32.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.42

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .0975 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4151

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 33.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.42

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .1005 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4182

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 34.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.42

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .1035 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4212

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 35.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.42

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .1066 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4243

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 36.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.43

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .1095 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4273

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 37.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.43

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .1127 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 1.4304

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 38.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.90 H= 1.200 COST= 11.43

***** SUMMARY INFO FOR PLAN N= 7 L= 2.90 H= 1.200 *****

HOURLY COSTS: ECL = 101.50 HOURS

% OF TIME UP & IN CONTROL: 98.52

NONCONFORMING ITEMS 10.7100 ALPHA = 0.004

FALSE ALARMS .1157 P = 0.857

ASSIGNABLE CAUSES .0197 ATS = 1.400 HOURS

SAMPLING .5880

TOTAL 11.4334

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 39.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.200 COST = 11.44

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1011 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4361

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 3.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 3 L = 1.85 H = 0.800 COST = 11.09

***** SUMMARY INFO FOR PLAN N = 3 L = 1.85 H = 0.800 *****

HOURLY COSTS: ECL = 102.07 HOURS

% OF TIME UP & IN CONTROL: 97.98

NONCONFORMING ITEMS 10.4498 ALPHA = 0.064

FALSE ALARMS 0.2353 P = 0.773

ASSIGNABLE CAUSES 0.0196 ATS = 1.035 HOURS

SAMPLING 0.3822

TOTAL 11.0869

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 40.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 2.95 H = 1.200 COST = 11.44

***** SUMMARY INFO FOR PLAN N = 7 L = 2.95 H = 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1037 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4387

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 41.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.44

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1063 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4413

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 42.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.44

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1089 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4439

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 43.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.45

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1115 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4465

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 44.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.45

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1141 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4491

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 45.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.45

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1167 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4517

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 46.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.45

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1193 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4543

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 47.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 2.95 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 2.95 H= 1.200 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.51

NONCONFORMING ITEMS 10.7273 ALPHA = 0.003

FALSE ALARMS 0.1219 P = 0.846

ASSIGNABLE CAUSES 0.0197 ATS = 1.419 HOURS

SAMPLING 0.5880

TOTAL 11.4569

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 48.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1057 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4594

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 49.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1079 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4616

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 4.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 4 L= 2.05 H= 0.900 COST= 11.14

***** SUMMARY INFO FOR PLAN N= 4 L= 2.05 H= 0.900 *****

HOURLY COSTS: ECL = 101.72 HOURS

% OF TIME UP & IN CONTROL: 98.31

NONCONFORMING ITEMS 10.4956 ALPHA = 0.040

FALSE ALARMS 0.1756 P = 0.829

ASSIGNABLE CAUSES 0.0197 ATS = 1.086 HOURS

SAMPLING 0.4509

TOTAL 11.1417

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4638

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 51.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.47

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1123 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4660

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 52.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.300 COST= 11.47

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.300 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.50

NONCONFORMING ITEMS 10.7396 ALPHA = 0.002

FALSE ALARMS 0.0896 P = 0.883

ASSIGNABLE CAUSES 0.0197 ATS = 1.471 HOURS

SAMPLING 0.6193

TOTAL 11.4681

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 53.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.300 COST= 11.47

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.300 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.50

NONCONFORMING ITEMS 10.7396 ALPHA = 0.002

FALSE ALARMS 0.0913 P = 0.883

ASSIGNABLE CAUSES 0.0197 ATS = 1.471 HOURS

SAMPLING 0.6193

TOTAL 11.4699

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 54.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.300 COST= 11.47

***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.300 *****

HOURLY COSTS: ECL = 101.52 HOURS

% OF TIME UP & IN CONTROL: 98.50

NONCONFORMING ITEMS 10.7396 ALPHA = 0.002

FALSE ALARMS 0.0930 P = 0.883

ASSIGNABLE CAUSES 0.0197 ATS = 1.471 HOURS

SAMPLING 0.6193

TOTAL 11.4716

ECONOMIC PARAMETER VALUES

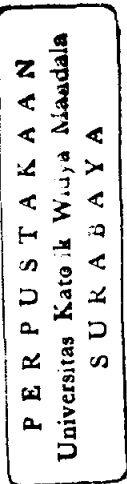
E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 55.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.300 COST= 11.47
***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.300 *****
HOURLY COSTS: ECL = 101.52 HOURS
% OF TIME UP & IN CONTROL: 98.50
NONCONFORMING ITEMS 10.7396 ALPHA = 0.002
FALSE ALARMS 0.0948 P = 0.883
ASSIGNABLE CAUSES 0.0197 ATS = 1.471 HOURS
SAMPLING 0.6193
TOTAL 11.4733

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 56.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.300 COST= 11.48
***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.300 *****
HOURLY COSTS: ECL = 101.52 HOURS
% OF TIME UP & IN CONTROL: 98.50
NONCONFORMING ITEMS 10.7396 ALPHA = 0.002
FALSE ALARMS 0.0965 P = 0.883
ASSIGNABLE CAUSES 0.0197 ATS = 1.471 HOURS
SAMPLING 0.6193
TOTAL 11.4750

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 57.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 8 L= 3.05 H= 1.300 COST= 11.48
***** SUMMARY INFO FOR PLAN N= 8 L= 3.05 H= 1.300 *****
HOURLY COSTS: ECL = 101.52 HOURS
% OF TIME UP & IN CONTROL: 98.50
NONCONFORMING ITEMS 10.7396 ALPHA = 0.002
FALSE ALARMS 0.0982 P = 0.883
ASSIGNABLE CAUSES 0.0197 ATS = 1.471 HOURS
SAMPLING 0.6193
TOTAL 11.4767



ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 58.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.48

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0845 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4783

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 59.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.48

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0859 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4797

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 60.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.48

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0874 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4812

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 61.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.48

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0889 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4826

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 62.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.48

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0903 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4841

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 63.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0918 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4856

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 64.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0932 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4870

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 65.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0947 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4885

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 66.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0961 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4899

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 67.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0976 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4914

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 68.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.0991 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4928

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 69.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.49

***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7548 ALPHA = 0.002

FALSE ALARMS 0.1005 P = 0.873

ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS

SAMPLING 0.6193

TOTAL 11.4943

ECONOMIC PARAMETER VALUES

```

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 70.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.50
***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****
HOURLY COSTS: ECL = 101.53 HOURS
% OF TIME UP & IN CONTROL: 98.49
NONCONFORMING ITEMS 10.7548 ALPHA = 0.002
FALSE ALARMS 0.1020 P = 0.873
ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS
SAMPLING 0.6193
TOTAL 11.4958

```

ECONOMIC PARAMETER VALUES

```

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 71.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.50
***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****
HOURLY COSTS: ECL = 101.53 HOURS
% OF TIME UP & IN CONTROL: 98.49
NONCONFORMING ITEMS 10.7548 ALPHA = 0.002
FALSE ALARMS 0.1034 P = 0.873
ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS
SAMPLING 0.6193
TOTAL 11.4972

```

ECONOMIC PARAMETER VALUES

```

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500
C0 = 10.00 C1 = 100.00 Y = 72.00
W = 2.00 A = 0.01 B = 0.10
L = 0.0100 DELTA = 1.50
D1 = 0 D2 = 0
OVERALL BEST PLAN: N= 8 L= 3.10 H= 1.300 COST= 11.50
***** SUMMARY INFO FOR PLAN N= 8 L= 3.10 H= 1.300 *****
HOURLY COSTS: ECL = 101.53 HOURS
% OF TIME UP & IN CONTROL: 98.49
NONCONFORMING ITEMS 10.7548 ALPHA = 0.002
FALSE ALARMS 0.1049 P = 0.873
ASSIGNABLE CAUSES 0.0197 ATS = 1.488 HOURS
SAMPLING 0.6193
TOTAL 11.4987

```

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 73.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.15 H = 1.300 COST = 11.50

***** SUMMARY INFO FOR PLAN N = 8 L = 3.15 H = 1.300 *****

HOURLY COSTS: ECL = 101.55 HOURS

% OF TIME UP & IN CONTROL: 98.47

NONCONFORMING ITEMS 10.7712 ALPHA = 0.002

FALSE ALARMS 0.0897 P = 0.863

ASSIGNABLE CAUSES 0.0197 ATS = 1.507 HOURS

SAMPLING 0.6193

TOTAL 11.4999

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 74.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 8 L = 3.15 H = 1.300 COST = 11.50

***** SUMMARY INFO FOR PLAN N = 8 L = 3.15 H = 1.300 *****

HOURLY COSTS: ECL = 101.55 HOURS

% OF TIME UP & IN CONTROL: 98.47

NONCONFORMING ITEMS 10.7712 ALPHA = 0.002

FALSE ALARMS 0.0909 P = 0.863

ASSIGNABLE CAUSES 0.0197 ATS = 1.507 HOURS

SAMPLING 0.6193

TOTAL 11.5012

3.6 Perubahan W

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 0.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 11.44

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0000 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4441

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 2.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.46

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0197 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.4638

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 10.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.54

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.0985 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.5426

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 20.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.64

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.1970 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.6411

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 30.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.74

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.2955 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.7396

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 40.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.84

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.3940 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.8381

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 50.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 11.94

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.4925 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 11.9366

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 60.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.04

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.5909 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.0351

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 70.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.13

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.6894 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.1335

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 80.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.23

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.7879 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.2320

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 90.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.33

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.8864 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.3305

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 100.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.43

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 0.9849 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.4290

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 110.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.53

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.0834 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.5275

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 120.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.63

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.1819 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.6260

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 130.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.72

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.2804 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.7245

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 140.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.82

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.3789 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.8230

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 150.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 12.92

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.4774 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 12.9215

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 160.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.02

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.5758 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.0200

***** ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 170.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.12

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.6743 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.1184

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 180.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.22

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.7728 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.2169

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 190.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.32

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.8713 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.3154

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 200.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.41

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 1.9698 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.4139

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 210.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.51

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.0683 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.5124

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 220.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.61

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.1668 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.6109

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 230.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 13.71

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.2653 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.7094

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 240.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 13.81

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.3638 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.8079

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 250.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 13.91

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.4623 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 13.9064

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 260.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 14.00

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.5607 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.0049

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 270.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.10

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.6592 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.1033

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 280.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.20

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.7577 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.2018

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 290.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.30

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.8562 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.3003

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 300.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 14.40

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 2.9547 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.3988

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 310.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 14.50

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.0532 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.4973

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 320.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 14.60

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.1517 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.5958

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 330.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.69

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.2502 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.6943

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 340.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.79

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.3487 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.7928

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 350.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.89

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.4472 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.8913

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 360.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 14.99

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.5456 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 14.9898

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 370.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.09

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.6441 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.0882

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 380.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.19

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.7426 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.1867

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 390.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.29

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.8411 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.2852

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 400.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.38

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 3.9396 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.3837

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 410.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.48

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.0381 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.4822

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 420.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.58

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.1366 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.5807

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 430.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.68

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.2351 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.6792

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 440.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 15.78

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.3336 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.7777

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 450.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 15.88

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.4321 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.8762

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 460.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 15.97

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.5305 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 15.9747

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 470.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 16.07

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.6290 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.0731

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 480.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.17

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.7275 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.1716

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 490.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.27

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.8260 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.2701

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 500.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.37

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 4.9245 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.3686

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 510.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.47

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.0230 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.4671

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 520.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.57

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.1215 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.5656

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 530.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.66

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.2200 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.6641

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 540.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 16.76

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.3185 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.7626

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 540.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 16.76

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.3185 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.7626

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 550.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N = 7 L = 3.00 H = 1.200 COST = 16.86

***** SUMMARY INFO FOR PLAN N = 7 L = 3.00 H = 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.4170 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.8611

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 560.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 16.96

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.5154 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 16.9596

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 570.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 17.06

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.6139 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 17.0581

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 580.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 17.16

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.7124 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 17.1565

ECONOMIC PARAMETER VALUES

E = 0.010 T0 = 0.100 T1 = 0.100 T2 = 0.500

C0 = 10.00 C1 = 100.00 Y = 50.00

W = 590.00 A = 0.01 B = 0.10

L = 0.0100 DELTA = 1.50

D1 = 0 D2 = 0

OVERALL BEST PLAN: N= 7 L= 3.00 H= 1.200 COST= 17.26

***** SUMMARY INFO FOR PLAN N= 7 L= 3.00 H= 1.200 *****

HOURLY COSTS: ECL = 101.53 HOURS

% OF TIME UP & IN CONTROL: 98.49

NONCONFORMING ITEMS 10.7459 ALPHA = 0.003

FALSE ALARMS 0.1101 P = 0.834

ASSIGNABLE CAUSES 5.8109 ATS = 1.439 HOURS

SAMPLING 0.5880

TOTAL 17.2550

4. Output Regresi

4.1 Perubahan a (fixed cost)

Regeresi L dengan a (fixed cost)

The regression equation is

L = 2.99 - 0.0211 a

Predictor	Coef	SE Coef	T	P
Constant	2.99018	0.00667	448.30	0.000
a	-0.021138	0.001841	-11.48	0.000

S = 0.02780 R-Sq = 67.7% R-Sq(adj) = 67.2%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.10192	0.10192	131.86	0.000
Residual Error	63	0.04869	0.00077		
Total	64	0.15062			

Unusual Observations

Obs	a	L	Fit	SE Fit	Residual	St
15	1.30	2.90000	2.96270	0.00478	-0.06270	-
2.29R						
34	3.20	2.85000	2.92254	0.00345	-0.07254	-
2.63R						
35	3.30	2.85000	2.92042	0.00347	-0.07042	-
2.55R						

R denotes an observation with a large standardized residual

Regeresi h dengan a (fixed cost)

The regression equation is
 $h = 1.59 + 0.432 a$

Predictor	Coef	SE Coef	T	P
Constant	1.59043	0.03249	48.95	0.000
a	0.431637	0.008967	48.13	0.000

S = 0.1354 R-Sq = 97.4% R-Sq(adj) = 97.3%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	42.499	42.499	2316.94	0.000
Residual Error	63	1.156	0.018		
Total	64	43.654			

Unusual Observations

Obs	a	h	Fit	SE Fit	Residual	St
Resid						
1	0.00	1.2000	1.5904	0.0325	-0.3904	-
2.97R						
2	0.01	1.2000	1.5947	0.0324	-0.3947	-
3.00R						
4	0.20	1.4000	1.6768	0.0310	-0.2768	-
2.10R						

R denotes an observation with a large standardized residual

Regeresi n dengan a (fixed cost)

The regression equation is
 $n = 8.56 + 0.498 a$

Predictor	Coef	SE Coef	T	P
Constant	8.5622	0.1194	71.69	0.000
a	0.49826	0.03296	15.12	0.000

S = 0.4978 R-Sq = 78.4% R-Sq(adj) = 78.0%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	56.632	56.632	228.50	0.000
Residual Error	63	15.614	0.248		
Total	64	72.246			

Unusual Observations

Obs	a	n	Fit	SE Fit	Residual	St
Resid						
1	0.00	7.0000	8.5622	0.1194	-1.5622	-
3.23R						
2	0.01	7.0000	8.5672	0.1192	-1.5672	-
3.24R						

R denotes an observation with a large standardized residual

4.2 Perubahan *b* (variable cost)

Regeresi n dengan *b* (variable cost)

The regression equation is
 $n = 6.01 - 0.746 a$

Predictor	Coef	SE Coef	T	P
Constant	6.0053	0.2399	25.03	0.000
a	-0.74573	0.06621	-11.26	0.000

S = 1.000 R-Sq = 66.8% R-Sq(adj) = 66.3%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	126.85	126.85	126.87	0.000
Residual Error	63	62.99	1.00		
Total	64	189.85			

Unusual Observations

Obs	a	n_1	Fit	SE Fit	Residual	St
1	0.00	11.000	6.005	0.240	4.995	
5.15R						
2	0.01	10.000	5.998	0.239	4.002	
4.12R						

R denotes an observation with a large standardized residual

Regeresi L dengan *b* (variable cost)

The regression equation is
 $L = 2.60 - 0.217 a$

Predictor	Coef	SE Coef	T	P
Constant	2.59547	0.05135	50.55	0.000
a	-0.21703	0.01417	-15.32	0.000

S = 0.2140 R-Sq = 78.8% R-Sq(adj) = 78.5%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	10.744	10.744	234.57	0.000
Residual Error	63	2.886	0.046		
Total	64	13.630			

Unusual Observations

Obs	a	L_1	Fit	SE Fit	Residual	St
1	0.00	3.5000	2.5955	0.0513	0.9045	
4.35R						
2	0.01	3.5000	2.5933	0.0512	0.9067	
4.36R						
3	0.10	3.0000	2.5738	0.0501	0.4262	
2.05R						

R denotes an observation with a large standardized residual

Regeresi h dengan b (variable cost)

The regression equation is
 $h = 2.35 + 0.608 a$

Predictor	Coef	SE Coef	T	P
Constant	2.3540	0.1494	15.75	0.000
a	0.60804	0.04124	14.74	0.000

S = 0.6229 R-Sq = 77.5% R-Sq(adj) = 77.2%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	84.334	84.334	217.38	0.000
Residual Error	63	24.442	0.388		
Total	64	108.776			

Unusual Observations

Obs	a	h_1	Fit	SE Fit	Residual	St
Resid						
1	0.00	0.3000	2.3540	0.1494	-2.0540	-
3.40R						
2	0.01	0.5000	2.3601	0.1491	-1.8601	-
3.08R						
3	0.10	1.2000	2.4149	0.1459	-1.2149	-
2.01R						

R denotes an observation with a large standardized residual

4.3 Perubahan C_0

Regeresi n dengan C_0

The regression equation is
 $n = 7.00 - 0.000000 C2$

Predictor	Coef	SE Coef	T	P
Constant	7.00000	0.00000	*	*
C2	-0.00000000	0.00000000	*	*

S = 0 R-Sq = *% R-Sq(adj) = *%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.00000000	0.00000000	*	*
Residual Error	135	0.00000000	0.00000000		
Total	136	0.00000000			

Regeresi L dengan C_0

The regression equation is
 $L = 3.00 - 0.000624 C2$

Predictor	Coef	SE Coef	T	P
Constant	3.00498	0.00166	1806.57	0.000
C2	-0.00062368	0.00003397	-18.36	0.000

S = 0.01291 R-Sq = 71.4% R-Sq(adj) = 71.2%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.056188	0.056188	337.15	0.000
Residual Error	135	0.022499	0.000167		
Total	136	0.078686			

Unusual Observations

Obs	C2	L	Fit	SE Fit	Residual	St
Resid						
72	34.0	2.95000	2.98377	0.00111	-0.03377	-
2.63R						
80	42.0	2.95000	2.97878	0.00112	-0.02878	-
2.24R						
81	43.0	2.95000	2.97816	0.00112	-0.02816	-
2.19R						
82	44.0	2.95000	2.97754	0.00113	-0.02754	-
2.14R						
90	52.0	3.00000	2.97255	0.00122	0.02745	
2.14R						
91	53.0	3.00000	2.97192	0.00123	0.02808	
2.18R						
92	54.0	3.00000	2.97130	0.00125	0.02870	
2.23R						
96	58.0	3.00000	2.96881	0.00132	0.03119	
2.43R						
97	59.0	3.00000	2.96818	0.00134	0.03182	
2.48R						
101	63.0	3.00000	2.96569	0.00142	0.03431	
2.67R						

R denotes an observation with a large standardized residual

Regeresi h dengan C₀

The regression equation is

$$h = 0.761 + 0.0277 C_2$$

Predictor	Coef	SE Coef	T	P
Constant	0.76096	0.09912	7.68	0.000
C2	0.027728	0.002024	13.70	0.000

S = 0.7692 R-Sq = 58.2% R-Sq(adj) = 57.9%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	111.06	111.06	187.68	0.000
Residual Error	135	79.88	0.59		
Total	136	190.94			

Unusual Observations

Obs	C2	h	Fit	SE Fit	Residual	St
Resid						
134	96.0	5.4000	3.4228	0.1369	1.9772	
2.61R						
135	97.0	6.1000	3.4505	0.1387	2.6495	
3.50R						
136	98.0	7.2000	3.4783	0.1405	3.7217	
4.92R						

137 99.0 9.0000 3.5060 0.1423 5.4940
7.27R

R denotes an observation with a large standardized residual

4.4 Perubahan C₁

Regresi n dengan C₁

The regression equation is

$$n = 7.69 - 0.00292 C_1$$

Predictor	Coef	SE Coef	T	P
Constant	7.68664	0.07858	97.82	0.000
C1	-0.0029186	0.0004076	-7.16	0.000

S = 0.2942 R-Sq = 45.7% R-Sq(adj) = 44.8%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	4.4363	4.4363	51.27	0.000
Residual Error	61	5.2780	0.0865		
Total	62	9.7143			

Regresi L dengan C₁

The regression equation is

$$L = 3.03 - 0.000149 C_1$$

Predictor	Coef	SE Coef	T	P
Constant	3.03411	0.00552	549.17	0.000
C1	-0.00014929	0.00002866	-5.21	0.000

S = 0.02068 R-Sq = 30.8% R-Sq(adj) = 29.7%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.011607	0.011607	27.14	0.000
Residual Error	61	0.026091	0.000428		
Total	62	0.037698			

Unusual Observations

Obs	C1	L	Fit	SE Fit	Residual	St
Resid						
43	225	2.95000	3.00052	0.00305	-0.05052	-
2.47R						
56	290	2.95000	2.99082	0.00431	-0.04082	-
2.02R						
58	300	3.05000	2.98932	0.00455	0.06068	
3.01R						
59	305	3.05000	2.98858	0.00466	0.06142	
3.05R						

R denotes an observation with a large standardized residual

Regresi h dengan C₁

The regression equation is

$$h = 2.33 - 0.00676 C_1$$

Predictor	Coef	SE Coef	T	P
Constant	2.3301	0.1566	14.88	0.000
C1	-0.0067598	0.0008122	-8.32	0.000

S = 0.5862 R-Sq = 53.2% R-Sq(adj) = 52.4%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	23.798	23.798	69.26	0.000
Residual Error	61	20.959	0.344		
Total	62	44.757			

Unusual Observations

Obs	C1	h	Fit	SE Fit	Residual	St
Resid						
1	15	5.5000	2.2287	0.1460	3.2713	
5.76R						
2	20	3.9000	2.1949	0.1425	1.7051	
3.00R						

R denotes an observation with a large standardized residual

4.5 Perubahan Y

Regresi n dengan Y

The regression equation is

$$n = 4.37 + 0.0606 Y$$

Predictor	Coef	SE Coef	T	P
Constant	4.3702	0.1904	22.96	0.000
Y	0.060626	0.004440	13.65	0.000

S = 0.8325 R-Sq = 71.9% R-Sq(adj) = 71.5%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	129.19	129.19	186.41	0.000
Residual Error	73	50.59	0.69		
Total	74	179.79			

Unusual Observations

Obs	Y	n	Fit	SE Fit	Residual	St
Resid						
1	0.0	1.0000	4.3702	0.1904	-3.3702	-
4.16R						
2	1.0	1.0000	4.4308	0.1865	-3.4308	-
4.23R						
3	2.0	2.0000	4.4914	0.1827	-2.4914	-
3.07R						

R denotes an observation with a large standardized residual

Regresi L dengan C₁

The regression equation is
 $L = 2.23 + 0.0151 Y$

Predictor	Coef	SE Coef	T	P
Constant	2.23018	0.05419	41.16	0.000
Y	0.015058	0.001264	11.91	0.000

S = 0.2370 R-Sq = 66.0% R-Sq(adj) = 65.6%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	7.9704	7.9704	141.91	0.000
Residual Error	73	4.1001	0.0562		
Total	74	12.0705			

Unusual Observations

Obs	Y	L	Fit	SE Fit	Residual	St
Resid						
1	0.0	1.6000	2.2302	0.0542	-0.6302	-
2.73R						
2	1.0	1.0000	2.2452	0.0531	-1.2452	-
5.39R						
3	2.0	1.4500	2.2603	0.0520	-0.8103	-
3.50R						

R denotes an observation with a large standardized residual

Regresi h dengan C₁

The regression equation is
 $h = 0.896 + 0.00690 Y$

Predictor	Coef	SE Coef	T	P
Constant	0.89551	0.03116	28.74	0.000
Y	0.0068962	0.0007269	9.49	0.000

S = 0.1363 R-Sq = 55.2% R-Sq(adj) = 54.6%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	1.6716	1.6716	90.00	0.000
Residual Error	73	1.3558	0.0186		
Total	74	3.0275			

Unusual Observations

Obs	Y	h	Fit	SE Fit	Residual	St
Resid						
1	0.0	0.1000	0.8955	0.0312	-0.7955	-
6.00R						
2	1.0	0.3000	0.9024	0.0305	-0.6024	-
4.54R						

R denotes an observation with a large standardized residual

4.6 Perub W

Regresi n dengan W

The regression equation is
 $n = 7.00 - 0.000000 W$

Predictor	Coef	SE Coef	T	P
Constant	7.00000	0.00000	*	*
W	-0.00000000	0.00000000	*	*

S = 0 R-Sq = *% R-Sq(adj) = *%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.000000000	0.000000000	*	*
Residual Error	61	0.000000000	0.000000000		
Total	62	0.000000000			

Regresi L dengan W

The regression equation is
 $L = 3.00 - 0.000000 W$

Predictor	Coef	SE Coef	T	P
Constant	3.00000	0.00000	*	*
W	-0.00000000	0.00000000	*	*

S = 0 R-Sq = *% R-Sq(adj) = *%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.000000000	0.000000000	*	*
Residual Error	61	0.000000000	0.000000000		
Total	62	0.000000000			

Regresi h dengan W

The regression equation is
 $h = 1.20 - 0.000000 W$

Predictor	Coef	SE Coef	T	P
Constant	1.20000	0.00000	*	*
W	-0.00000000	0.00000000	*	*

S = 0 R-Sq = *% R-Sq(adj) = *%

Analysis of Variance

Source	DF	SS	MS	F	P
Regression	1	0.000000000	0.000000000	*	*
Residual Error	61	0.000000000	0.000000000		
Total	62	0.000000000			

Here is the submission from the July 1994 issue of JQT.
 "Economic, Statistical, and Economic-Statistical Xbar Chart Design"
 by Thomas P. McWilliams
 JQT, vol. 26, no. 3, pp. 227-238, July 1994

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C
C PROGRAM TO DETERMINE ECONOMIC, STATISTICAL,
C OR ECONOMIC-STATISTICAL X-BAR CHART PARAMETERS
C
  DIMENSION DEL(11),ARLB(11),POWER(11)
  DIMENSION XLVAL(100),NMIN(100),NMAX(100)
  CHARACTER*16 OUTFIL,INSTAT,INECON
  CHARACTER*1 GO
  REAL LAMBDA
  COMMON/COSTS/LAMBDA,DELTA,E,T0,T1,T2,DELTA1,
&DELTA2,C0,C1,Y,W,A,B,HROUND,HMAX
C
C XMIN, XMAX, AND XDEL DETERMINE THE CONTROL LIMIT
C SEARCH GRID; AND NHIGH DETERMINES THE MAX SAMPLE
C SIZE CONSIDERED
C
  DATA XMIN,XMAX,XDEL/1.0,3.5,.05/
  DATA NHIGH/25/
  DATA SMALL,BIG/1.0E-5,1.0E10/
  NCYC=(XMAX-XMIN+SMALL)/XDEL+1.
  DO 5 I=1,NCYC
    XLVAL(I)=XMIN+FLOAT(I-1)*XDEL
  5 CONTINUE
  WRITE(*,1000)
  READ(*,'(A)') OUTFIL
C
C OPEN STATEMENTS MAY REQUIRE MODIFICATION
C FOR DIFFERENT SYSTEMS
C
  OPEN(UNIT=10,FILE=OUTFIL,STATUS='UNKNOWN')
10 WRITE(*,1100)
  READ(*,*) MENU
  IF(MENU.EQ.0) STOP
  GOTO(100,200,300,400,500,600,700),MENU
C
C OPTION 1: INPUT/REPLACE STATISTICAL DATA
C
100 WRITE(*,1200)
  READ(*,*)INTYPE
  IF(INTYPE.EQ.0)THEN
C
C OPTION 1: INTERACTIVE INPUT
C
    WRITE(*,1300)
    READ(*,*) NUMARL
    DEL(1)=0.
    WRITE(*,1350)
    READ(*,*) ARLB(1)
    DO 130 J=2,NUMARL
125  WRITE(*,1400) J
130  READ(*,*) ARLB(J),DEL(J)
    WRITE(*,1450)
    READ(*,*) IDEC
    ELSE
C
C OPTION 1: FILE INPUT

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```

C
  WRITE(*,1500)
  READ(*,'(A)') INSTAT
  OPEN(UNIT=11,FILE=INSTAT,STATUS='OLD')
  READ(11,*) NUMARL
  READ(11,*) ARLB(1)
  DO 140 J=2,NUMARL
140  READ(11,*) ARLB(J),DEL(J)
    READ(11,*) IDEC
  ENDIF
  DO 160 I=1,NUMARL
160  POWER(I)=1./ARLB(I)
    GOTO 10
C
C OPTION 2: INPUT/REPLACE ECONOMIC DATA
C
200 WRITE(*,1200)
  READ(*,*) INTYPE
  IF(INTYPE.EQ.0) THEN
C
C OPTION 2: INTERACTIVE INPUT
C
    WRITE(*,2100)
    READ(*,*) E,T0,T1,T2
    WRITE(*,2101)
    READ(*,*) C0,C1,Y,W,A,B
    WRITE(*,2102)
    READ(*,*) LAMBDA,DELTA
    WRITE(*,2103)
    READ(*,*) DELTA1,DELTA2
  ELSE
C
C OPTION 2: FILE INPUT
C
    WRITE(*,1500)
    READ(*,'(A)') INECON
    OPEN(UNIT=12,FILE=INECON,STATUS='OLD')
    READ(12,*) E,T0,T1,T2
    READ(12,*) C0,C1,Y,W,A,B
    READ(12,*) LAMBDA,DELTA
    READ(12,*) DELTA1,DELTA2
  ENDIF
  ID1=IFIX(DELTA1+SMALL)
  ID2=IFIX(DELTA2+SMALL)
  WRITE(*,2500) E,T0,T1,T2,C0,C1,Y,W,A,B,LAMBDA,
    &DELTA,ID1,ID2
  WRITE(10,2500) E,T0,T1,T2,C0,C1,Y,W,A,B,LAMBDA,
    &DELTA,ID1,ID2
  GOTO 10
C
C OPTION 3: STATISTICAL PERFORMANCE OF A GIVEN DESIGN
C
300 CONTINUE
  WRITE(*,2600)
  READ(*,*) N,XL
  CALL STATS(XL,N,NUMARL,DEL,ARLB,IDEC)
  GOTO 10
C
C OPTION 4: ECONOMIC PERFORMANCE OF A GIVEN DESIGN
C
400 CONTINUE
  WRITE(*,2700)

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```

READ(*,*) NSAMP,XL,H
CALL COST(NSAMP,H,XL,VALUE,1,ALPHA,P,ECL,CTIME)
GOTO 10
C
C OPTION 5: FIND STATISTICAL DESIGNS
C
500 CONTINUE
  CALL NRANGE(NCYC,XLVAL,NUMARL,DEL,POWER,IDEC,
    &NHIGH,IMIN,NMIN,NMAX)
  IF(IMIN.EQ.-99) GOTO 10
  CALL OUTPUT(IMIN,NCYC,XLVAL,NMIN,NMAX,NUMARL,
    &DEL,ARLB,IDEC)
  GOTO 10
C
C OPTION 6: FIND ECONOMIC DESIGN
C
600 CONTINUE
  WRITE(*,2800)
  READ(*,*) HROUND,HMAX
  IMIN = 1
  DO 610 I=1,NCYC
    NMIN(I)=1
    NMAX(I)=NHIGH
610 CONTINUE
  CALL BSTPLN(IMIN,NCYC,XLVAL,NMIN,NMAX,
    &NB,XLBEST,HB)
  CALL COST(NB,HB,XLBEST,VALUE,1,ALPHA,P,ECL,
    &CTIME)
  GOTO 10
C
C OPTION 7: FIND ECONOMIC-STATISTICAL DESIGN
C
700 CONTINUE
  WRITE(*,2800)
  READ(*,*) HROUND,HMAX
  CALL NRANGE(NCYC,XLVAL,NUMARL,DEL,POWER,IDEC,
    &NHIGH,IMIN,NMIN,NMAX)
  IF(IMIN.EQ.-99) GOTO 10
  CALL BSTPLN(IMIN,NCYC,XLVAL,NMIN,NMAX,
    &NB,XLBEST,HB)
  CALL STATS(XLBEST,NB,NUMARL,DEL,ARLB,IDEC)
  WRITE(*,2850)
  READ(*, '(A)') GO
  CALL COST(NB,HB,XLBEST,VALUE,1,ALPHA,P,ECL,
    &CTIME)
  GOTO 10

1000 FORMAT('/ ENTER A FILE NAME FOR OUTPUT',
  &' (<= 16 CHARACTERS): ')
1100 FORMAT(/2X,'INPUT:',T11,'0 TO TERMINATE'/
  &1X,T11,'1 TO INPUT/REPLACE STATISTICAL DATA'
  &/1X,T11,'2 TO INPUT/REPLACE ECONOMIC DATA'
  &/1X,T11,'3 TO EVALUATE STATISTICAL',
  &' PERFORMANCE OF A GIVEN DESIGN'/1X,T11,
  &' 4 TO EVALUATE ECONOMIC PERFORMANCE OF A',
  &' GIVEN DESIGN'/1X,T11,'5 TO FIND',
  &' STATISTICAL DESIGNS'/1X,T11,'6 TO FIND',
  &' ECONOMIC DESIGN'/1X,T11,'7 TO FIND',
  &' ECONOMIC-STATISTICAL DESIGN'/)
1200 FORMAT('/ DO YOU WANT TO USE INTERACTIVE',
  &' INPUT OR AN INPUT FILE?/1X,T6,
  &' 0 = INTERACTIVE INPUT/1X,T6,

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      &' I = INPUT FILE')
1300 FORMAT(/ INPUT NUMBER OF CONSTRAINTS',
      &' (SHOULD BE >= 2): ')
1350 FORMAT(/ INPUT LOWER ARL BOUND AT DELTA = 0: ')
1400 FORMAT(/ INPUT ARL BOUND AND DELTA VALUE FOR',
      &' CONSTRAINT NUMBER',I3,': ')
1450 FORMAT(/ INPUT 0 IF 2ND ARL IS UPPER BOUND,',
      &' 1 IF LOWER BOUND: ')
1500 FORMAT(/ ENTER A FILE NAME FOR INPUT',
      &' (<= 16 CHARACTERS): ')
2100 FORMAT(/ ENTER E, T0, T1, T2: ')
2101 FORMAT(/ ENTER C0, C1, Y, W, A, B: ')
2102 FORMAT(/ ENTER LAMBDA AND DELTA: ')
2103 FORMAT(/ ENTER D1 AND D2: ')
2500 FORMAT(/IX,T14,'ECONOMIC PARAMETER VALUES'
      &' 1X,T12,29(=)'/ E = ',F6.3,4X,T0 = ',
      &' F6.3,4X,T1 = ',F6.3,4X,T2 = ',F6.3/
      &' C0 = ',F8.2,4X,C1 = ',F8.2,4X,Y = ',F8.2,
      &' 4X,W = ',F7.2,4X,A = ',F7.2,4X,B = ',
      &' F7.2/ L = ',F7.4,4X,DELTA = ',F5.2/
      &' D1 = ',I1,4X,D2 = ',I1//)
2600 FORMAT(/ INPUT DESIGN PARAMETERS N AND L: ')
2700 FORMAT(/ INPUT DESIGN PARAMETERS N, L, AND H: ')
2800 FORMAT(/ INPUT SMALLEST MEANINGFUL INCREMENT',
      &' FOR TIME BETWEEN SAMPLES H (IN HRS.)/'
      &' AND MAXIMUM TIME BETWEEN SAMPLES: ')
2850 FORMAT(/ INPUT ANY VALUE AND ',
      &'PRESS ENTER TO CONTINUE ')
      END
C
      SUBROUTINE NRANGE(NCYC,XLVAL,NUMARL,DEL,POWER,
      &IDEC,NHIGH,IMIN,NMIN,NMAX)
C
C FOR EACH CONTROL LIMIT IN GRID (INDEXED BY I)
C FIND CORRESPONDING RANGE OF SAMPLE SIZES
C THAT MEETS ARL CRITERIA
C
      DIMENSION DEL(11),POWER(11),PWR(11)
      DIMENSION XLVAL(100),NMIN(100),NMAX(100)
      IARL=3
      IF(IDEC.EQ.0) IARL=2
      XLMIN=PERNOR(1.-POWER(1)/2.)
C
C FIND INDEX OF SMALLEST CONTROL LIMIT VALUE THAT
C MEETS ALPHA CRITERIA. RESULT = IMIN.
C
      DO 100 I=1,NCYC
        IMIN=I
        IF(XLVAL(I).GT.XLMIN) GOTO 150
100  CONTINUE
C
C NO CONTROL LIMITS IN SEARCH GRID MEET ALPHA SPEC
C SET IMIN = -99 TO INDICATE INFEASIBILITY AND RETURN
C
      WRITE(*,1100)
      IMIN=-99
      RETURN
150  CONTINUE
      WRITE(*,1000) XLMIN,XLVAL(IMIN)
      WRITE(10,1000) XLMIN,XLVAL(IMIN)
C
C VARIABLE IND INDICATES WHETHER A FEASIBLE CONTROL

```

```

C LIMIT/SAMPLE SIZE COMBINATION HAS BEEN FOUND
C
C CYCLE ON CONTROL LIMITS, FINDING CORRESPONDING
C RANGE OF FEASIBLE SAMPLE SIZE VALUES
C

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```

    IND=0
    DO 500 I=IMIN,NCYC
        NMIN(I)=1
        NMAX(I)=NHIGH
C

```

```

C
C IF 2ND ARL CONSTRAINT IS A LOWER BOUND (IDEC = 1),
C FIND MAXIMUM N VALUE
C

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```

    IF(IDEC.EQ.1) THEN
        FAC=SQRT(FLOAT(NHIGH))*DEL(2)
        PWR(2)=1.-PNORM(XLVAL(I)-FAC)
    & + PNORM(-XLVAL(I)-FAC)
        IF(PWR(2).LE.POWER(2)) GOTO 430
        DO 400 N=1,NHIGH
            NMAXT=N
            FAC=SQRT(FLOAT(N))*DEL(2)
            PWR(2)=1.-PNORM(XLVAL(I)-FAC)
        & + PNORM(-XLVAL(I)-FAC)
            IF(PWR(2).GT.POWER(2)) GOTO 420
400    CONTINUE
420    NMAX(I)=NMAXT-1
430    CONTINUE
        ENDIF
C

```

```

C
C FIND MIN N TO MEET MIN ARL (POWER) SPECS
C

```

```

    IF(IARL.GT.NUMARL) GOTO 460
    MAXVAL=0
    DO 450 J=IARL,NUMARL
        XPWR=((XLVAL(I)-PERNOR(1.-POWER(J)))
    & /DEL(J))**2
        NPWR=1+XPWR
        IF(NPWR.GT.MAXVAL) MAXVAL=NPWR
450    CONTINUE
    NMIN(I)=MAXVAL
460    CONTINUE
C

```

```

C CHECK TO SEE IF WE HAVE A FEASIBLE COMBINATION
C

```

```

    IF((NMIN(I).LE.NMAX(I)).AND.(IND.EQ.0))IND=I
500 CONTINUE
C

```

```

C IF NO FEASIBLE COMBOS, SET IMIN=-99 AND RETURN.
C OTHERWISE, MAKE IMIN THE SMALLEST INDEX THAT
C MEETS ALPHA AND ARL CRITERIA
C

```

```

    IF(IND.EQ.0) THEN
        WRITE(*,1100)
        IMIN=-99
    ELSE
        IMIN=IND
    ENDIF
    RETURN
1000 FORMAT('/ MINIMUM L FOR ALPHA (1ST ARL)',
    & ' CRITERION = ',F4.2,' MINIMUM L IN',
    & ' SEARCH GRID = ',F4.2)
1100 FORMAT('/ NO STATISTICALLY FEASIBLE',

```

```

&' SOLUTIONS FOUND!!'//)
END
C
SUBROUTINE BSTPLN(IMIN,NCYC,XLVAL,NMIN,NMAX,
&NB,XLBEST,HB)
C
C USE GRID SEARCH ON CONTROL LIMITS AND SAMPLE SIZES.
C OUTPUT BEST SAMPLE SIZE, CONTROL LIMIT, TIME
C INTERVAL: NB, XLBEST, HB.
C
DIMENSION XLVAL(100),NMIN(100),NMAX(100)
DIMENSION BESTCO(100),BESTH(100)
INTEGER BESTN(100)
DATA BIG/1.0E10/
WRITE(*,1000)
WRITE(10,1000)
C
C FIND BEST PLAN AT CONTROL LIMIT INDEXED BY I
C
DO 300 I=IMIN,NCYC
  II=I
  BESTCO(I)=BIG
  BESTN(I)=-1
  IF(NMIN(I).GT.NMAX(I)) GOTO 300
  DO 100 N=NMIN(I),NMAX(I)
    CALL COST(N,H,XLVAL(II),VALUE,0,ALPHA,P,
& ECL,CTIME)
    IF(VALUE.LT.BESTCO(I)) THEN
      BESTCO(I)=VALUE
      BESTN(I)=N
    ENDIF
100 CONTINUE
  CALL COST(BESTN(II),BESTH(II),XLVAL(II),
& VALUE,0,ALPHA,P,ECL,CTIME)
  HP=1.0E8
  IF(P.GT.1.0E-8)HP=BESTH(II)/P
  WRITE(*,1100) XLVAL(I),BESTN(I),BESTH(I),
& BESTCO(I),ALPHA,P,HP,CTIME
  WRITE(10,1100) XLVAL(I),BESTN(I),BESTH(I),
& BESTCO(I),ALPHA,P,HP,CTIME
300 CONTINUE
C
C FIND OVERALL BEST PLAN
C
COSTB=BIG
DO 400 I=IMIN,NCYC
  IF(BESTCO(I).LT.COSTB) THEN
    XLBEST=XLVAL(I)
    COSTB=BESTCO(I)
    NB=BESTN(I)
    HB=BESTH(I)
  ENDIF
400 CONTINUE
WRITE(*,1200) NB,XLBEST,HB,COSTB
WRITE(10,1200) NB,XLBEST,HB,COSTB
RETURN
1000 FORMAT(/' RESULTS SUMMARY.....'/' CONTROL',
&3X,'BEST',8X,'BEST',46X,'% IN/' LIMIT',
&6X,'N',11X,'H',8X,'COST',7X,'ALPHA',6X,'P',
&5X,'ATS',8X,'CONTROL'/)
1100 FORMAT(1X,F5.3,5X,I3,3X,F10.3,3X,G12.4,2X,F5.3,
&3X,F5.3,G12.4,3X,F6.2)

```



```

1200 FORMAT(// ' OVERALL BEST PLAN: N=',I3,' L=',
&F5.2,' H=',F8.3,' COST=',G12.4)
END
C
SUBROUTINE COST(NSAMP,H,XLVAL,VALUE,
&IND,ALPHA,P,ECL,CTIME)
C
C SUBROUTINE TO EVALUATE COST FUNCTION
C
C IND = 0: FIND BEST H VIA QUADRATIC APPROX.
C AND EVALUATE COST FUNCTION. BEST
C H IS ROUNDED ACCORDING TO HROUND
C IND = 1: EVALUATE COST FUNCTION AT GIVEN H
C AND PROVIDE BREAKDOWN INFO
C
REAL LAMBDA
DOUBLE PRECISION DLAM,PROD
COMMON/COSTS/LAMBDA,DELTA,E,T0,T1,T2,
&DELTA1,DELTA2,C0,C1,Y,W,A,B,HROUND,HMAX
DATA SMALL,BIG/1.0E-8,1.0E10/
XN=NSAMP
ALPHA=2.*PNORM(-XLVAL)
FAC=DELTA*SQRT(XN)
P=PNORM(-XLVAL-FAC)+PNORM(-XLVAL+FAC)
CONT=XLVAL
IF((ALPHA.LT.SMALL).OR.(P.LT.SMALL))
&WRITE(*,1050)NSAMP,CONT
ARL1=1./ALPHA
ARL2=1./P
ABSUM=A+B*XN
STERM=(1.-DELTA1)*T0/ARL1
XLINV=1./LAMBDA
DELSUM=DELTA1*T1+DELTA2*T2
PLUSNE=XN*E+DELSUM
C
C NEXT SECTION CALCULATES BEST H VALUE
C
IF(IND.EQ.0) THEN
A0=Y/ARL1+ABSUM*(1.+LAMBDA*PLUSNE)
A1=C0/LAMBDA+C1*PLUSNE-.5*Y/ARL1+W
& +ABSUM*(-.5+ARL2)
A2=C1*(-.5+ARL2)/LAMBDA+(Y/ARL1+ABSUM)/12.
A3=C1/(12.*LAMBDA)
B0=STERM
B1=XLINV-.5*STERM+XN*E+T1+T2
B2=STERM/12.+XLINV*(-.5+ARL2)
B3=1./(12.*LAMBDA)
CNST=B0*A1-A0*B1
XFAC=2.*(A2*B0-A0*B2)
X2FAC=3.*A3*B0+2.*A2*B1+A1*B2-3.*A0*B3
& -2.*A1*B2-A2*B1
ROOTIN=XFAC*XFAC-4.*X2FAC*CNST
IF(ROOTIN.LT.0.0) THEN
WRITE(*,1060)NSAMP,CONT
VALUE=BIG
RETURN
ENDIF
ROOT=SQRT(ROOTIN)
X1VAL=(-XFAC+ROOT)/(2.*X2FAC)
H=X1VAL/LAMBDA
HLOW=INT(H/HROUND)*HROUND
HHIGH=HLOW+HROUND

```

```

ENDIF
IF((IND.EQ.0).AND.(H.LT.SMALL)) THEN
  VALUE=BIG
  RETURN
ENDIF
C
C CONTINUE WITH COST FUNCTION CALCULATION
C IF IND = 0, ALSO FIND WHICH BRACKETING ROUNDED
C H-VALUE, HLOW OR HHIGH, MINIMIZES COST
C
C IPASS VARIABLE REPRESENTS WHICH "PASS" THROUGH
C COST FUNCTION EVALUATION IS BEING MADE.
C WHEN IPASS=0, H=HLOW. WHEN IPASS=1,
C H=HHIGH. IPASS=2 MEANS COST WAS MINIMIZED
C AT HLOW AND RECALCULATION IS REQUIRED.
C IPASS=3 MEANS OPTIMAL H EXCEEDED HMAX, AND
C RECALCULATION AT HMAX IS REQUIRED.
C
  IF(IND.EQ.0) THEN
    H=HLOW
    IPASS=0
    IF(H.LT.SMALL) THEN
      VALUE=BIG
      GOTO 200
    ENDIF
  ENDIF
100 CONTINUE
  DLAM=LAMBDA
  PROD=DLAM*H
  S=1.D0/(DEXP(PROD)-1.D0)
  TAU=1./DLAM-H*S
  ECL=1./DLAM+STERM*S-TAU+XN*E
  ECL=ECL+H*ARL2+T1+T2
  TERM1=-TAU+XN*E+H*ARL2+DELSUM
  TR1=C0/DLAM+C1*TERM1
  TR2=S*Y/ARL1
  TR3=(1./DLAM+TERM1)*ABSUM/H
  VALUE=(TR1+TR2+W+TR3)/ECL
200 CONTINUE
  IF(IND.EQ.0) THEN
    IF(IPASS.EQ.3) GOTO 300
    IF(IPASS.EQ.0) THEN
      VALUE1=VALUE
      IPASS=1
      H=HHIGH
      GOTO 100
    ELSE IF(IPASS.EQ.1) THEN
      IF(VALUE1.LT.VALUE) THEN
        H=HLOW
        IPASS=2
        GOTO 100
      ENDIF
    ENDIF
  ENDIF

  IF((IND.EQ.0).AND.(H.GT.HMAX)) THEN
    H=HMAX
    IPASS=3
    GOTO 100
  ENDIF
300 CONTINUE
  CTIME=100./(DLAM*ECL)

```

```

C
C NOW GIVE DETAILED INFO IF REQUESTED
C
  IF(IND.EQ.1) THEN
    HP=1.0E8
    IF(P.GT.1.0E-8) HP=H/P
    WRITE(*,1000)NSAMP,CONT,H,ECL,CTIME,TR1/ECL,
    & ALPHA,TR2/ECL,P,W/ECL,HP,TR3/ECL,VALUE
    WRITE(10,1000)NSAMP,CONT,H,ECL,CTIME,TR1/ECL,
    & ALPHA,TR2/ECL,P,W/ECL,HP,TR3/ECL,VALUE
    ENDIF
    RETURN
1000 FORMAT(/' ***** SUMMARY INFO FOR PLAN N=',
  &I3,2X,' L = ',F6.2,' H = ',F7.3,' *****'
  &/' HOURLY COSTS:',T42,'ECL = ',F8.2,
  &' HOURS/T42,% OF TIME UP & IN CONTROL: ',
  &F6.2/' NONCONFORMING ITEMS',T26,
  &F9.4,T42,'ALPHA = ',F5.3/' FALSE ALARMS',
  &T26,F9.4,T42,'P = ',F5.3/
  &' ASSIGNABLE CAUSES',T26,F9.4,T42,'ATS = ',
  &F8.3,' HOURS/' SAMPLING',T26,F9.4//16X,
  &'TOTAL',T26,F9.4//1X,71('*')/)
1050 FORMAT(/' ALPHA OR P NEAR ZERO IN COST, MAY',
  &' HAVE ACCURACY PROBLEMS/'
  &' N = ',I4,' CONTROL LIMIT = ',F7.2/)
1060 FORMAT(/' MINUS VALUE UNDER SQUARE RT AT',
  &' N = 0',I4,' CONTROL LIMIT = ',F7.2/)
  END
C
  SUBROUTINE STATS(XL,N,NUMARL,DEL,ARLB,IDEC)
C
C EVALUATE STATISTICAL PERFORMANCE OF A GIVEN PLAN,
C COMPARE TO ARL CONSTRAINTS
C
  DIMENSION DEL(11),ARLB(11)
  CHARACTER*3 YORN(11)
  CHARACTER*1 INEQ(11)
  DATA INEQ/'>','10*','</'
  IF(IDEC.EQ.1)INEQ(2)='>'
  XN=N
  WRITE(*,1000) XL,N
  WRITE(10,1000) XL,N
  YORN(1)='NO'
  J=1
  ALPHA=2.*(1.-PNORM(XL))
  ARL1=1./ALPHA
  IF(ARL1.GT.ARLB(1)) YORN(1)='YES'
  WRITE(*,1001) J,DEL(1),INEQ(1),ARLB(1),ARL1,
  &ALPHA,YORN(1)
  WRITE(10,1001) J,DEL(1),INEQ(1),ARLB(1),ARL1,
  &ALPHA,YORN(1)
  DO 100 J=2,NUMARL
    YORN(J)='NO'
    FAC1=SQRT(XN)*DEL(J)
    IF((J.EQ.2).AND.(IDEC.EQ.1))THEN
      POWER1=1.-PNORM(XL-FAC1)+PNORM(-XL-FAC1)
      ARL1=1./POWER1
      IF(ARL1.GT.ARLB(J)) YORN(J)='YES'
    ELSE
      POWER1=1.-PNORM(XL-FAC1)
      ARL1=1./POWER1
      IF(ARL1.LT.ARLB(J)) YORN(J)='YES'
    
```

```

ENDIF
WRITE(*,1001) J,DEL(J),INEQ(J),ARLB(J),
& ARL1,POWER1,YORN(J)
WRITE(10,1001) J,DEL(J),INEQ(J),ARLB(J),
& ARL1,POWER1,YORN(J)
100 CONTINUE
WRITE(*,1002)
WRITE(10,1002)
1000 FORMAT(1X,T19,'STATISTICAL DATA FOR PLAN ',
&'L = ',F4.2,' N = ',I3//1X,T8,69('=')1X,
&T9,'BOUND',T16,'DELTA',T24,'ARL BOUND',T40,
&'ARL',T50,'POWER',T59,'MEETS CONSTRAINT?'/
&1X,T8,69('='))
1001 FORMAT(1X,T10,I2,T17,F4.2,T24,A1,F7.2,T38,F7.2,
&T50,F5.3,T66,A3)
1002 FORMAT(1X,T8,69('=')//
&' ALPHA=1ST POWER VALUE'//)
RETURN
END
C
SUBROUTINE OUTPUT(IMIN,NCYC,XLVAL,NMIN,NMAX,
&NUMARL,DEL,ARLB,IDEC)
C
C OUTPUTS STATISTICAL PERFORMANCE DATA
C FOR FEASIBLE PLANS
C
DIMENSION XLVAL(100),NMIN(100),NMAX(100),
&DEL(11),ARLB(11)
CHARACTER*1 INEQ(11)
DATA INEQ/'>','10*','<'/
IF(IDEC.EQ.1) INEQ(2)='>'
DO 500 I=IMIN,NCYC
IF(NMIN(I).GT.NMAX(I)) GOTO 500
WRITE(*,1000) XLVAL(I),NMIN(I),NMAX(I)
WRITE(10,1000) XLVAL(I),NMIN(I),NMAX(I)
J=1
ALPHA=2.*(1.-PNORM(XLVAL(I)))
ARL1=1./ALPHA
WRITE(*,1001) J,DEL(1),INEQ(1),ARLB(1),ARL1,
& ALPHA,ARL1,ALPHA
WRITE(10,1001) J,DEL(1),INEQ(1),ARLB(1),ARL1,
& ALPHA,ARL1,ALPHA
DO 100 J=2,NUMARL
FAC1=SQRT(FLOAT(NMIN(I)))*DEL(J)
FAC2=SQRT(FLOAT(NMAX(I)))*DEL(J)
IF((J.EQ.2).AND.(IDEC.EQ.1)) THEN
POWER1=1.-PNORM(XLVAL(I)-FAC1)
& +PNORM(-XLVAL(I)-FAC1)
POWER2=1.-PNORM(XLVAL(I)-FAC2)
& +PNORM(-XLVAL(I)-FAC2)
ELSE
POWER1=1.-PNORM(XLVAL(I)-FAC1)
POWER2=1.-PNORM(XLVAL(I)-FAC2)
ENDIF
ARL1=1./POWER1
ARL2=1./POWER2
WRITE(*,1001) J,DEL(J),INEQ(J),ARLB(J),
& ARL1,POWER1,ARL2,POWER2
WRITE(10,1001) J,DEL(J),INEQ(J),ARLB(J),
& ARL1,POWER1,ARL2,POWER2
100 CONTINUE
WRITE(*,1002)

```

```

WRITE(10,1002)
WRITE(*,1030)
READ(*,*) NEXT
IF(NEXT.EQ.0) GOTO 600
500 CONTINUE
600 CONTINUE
RETURN
1000 FORMAT(/' CONTROL LIMIT: L = ',F4.2//1X,T9,
&' STATISTICAL DATA FOR MINIMUM AND MAXIMUM',
&' FEASIBLE N-VALUES'/1X,72('='),1X,T33,
&' MINIMUM N = ',I3,T56,' MAXIMUM N = ',I3//
&' BOUND',T9,' DELTA',T18,' ARL BOUND',T34,' ARL',
&T42,' POWER',T57,' ARL',T65,' POWER'/1X,72('='))
1001 FORMAT(1X,T3,I2,T10,F4.2,T18,A1,T19,F7.2,T32,
&F7.2,T42,F5.3,T55,F7.2,T65,F5.3)
1002 FORMAT(1X,72('='))' ALPHA=1ST POWER VALUE'//
1030 FORMAT(' INPUT 1 TO SHOW FEASIBLE N VALUES FOR',
&' NEXT L, 0 TO RETURN TO MENU'//)
END
C
FUNCTION PNORM(X)
C
C NORMAL CDF CALCULATOR. USES APPROXIMATION FROM
C ABRAMOWITZ AND STEGUN'S HANDBOOK OF
C MATHEMATICAL FUNCTIONS
C
C IF Y > 6, REPLACES WITH Y=6 TO AVOID UNDERFLOW
C
DIMENSION C(7)
DATA C/.31938153,-.356563782,1.781477937,
&-1.821255978,1.330274429,.2316419,
&2.506628725/
Y=ABS(X)
IF(Y.GT.6.) Y=6.
Z=1./(1.+C(6)*Y)
S1=((C(5)*Z+C(4))*Z+C(3))*Z+C(2)
S=(S1*Z+C(1))*Z
PNORM=S*EXP(-Y*Y/2.)/C(7)
IF(X.GT.0.) PNORM=1.-PNORM
RETURN
END
C
C
C FUNCTION TO FIND PERCENTILES OF NORMAL CDF
C BASED ON ROUTINE FROM COOKE, CRAVEN AND CLARGE
C (BASIC STATISTICAL COMPUTING, 2ND ED.)
C
DATA A1,A2,A3,A4,A5,A6/2.515517,0.802853,
&0.010328,1.432788,0.189269,0.001308/
Q0=0.5-ABS(P-.5)
W=SQRT(-2*ALOG(Q0))
W1=A1+W*(A2+A3*W)
W2=1+W*(A4+W*(A5+A6*W))
PERNOR=W-W1/W2
PERNOR=PERNOR*SIGN(1.,P-.5)
RETURN
END

```

